MODEL G0555X
14" EXTREME SERIES BANDSAW
OWNER'S MANUAL

#TR8670 PRINTED IN TAIWAN

⚠ WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.

Failure to read, understand and follow the instructions given in this manual may result in serious personal injury, including amputation, electrocution or death.

The owner of this machine/equipment is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, blade/cutter integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

⚠ WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

Table of Contents

INTRODUCTION

Foreword

We are proud to offer the Model G0555X 14" Extreme Series Bandsaw. This machine is part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model G0555X. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible.

The specifications, drawings, and photographs illustrated in this manual represent the Model G0555X as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

Contact Info

If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
C/O Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

We stand behind our machines. If you have any service questions or parts requests, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: http://www.grizzly.com

MACHINE DATA SHEET

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

MODEL G0555X 14" EXTREME SERIES BANDSAW

Overall Dimensions:

Table Size	14" x 20½" x 1½"
Height From Floor To Table	44"
Resaw Fence Height	6"H x 20"L
Overall Height	67¼"
Overall Width	30"
Overall Depth	26"
Base Footprint	17¼"W x 16"D
Machine Weight	236 lbs.
Box 1 Size (Bandsaw)	44"L x 21"W x 20"H, 199 LBS
Box 2 Size (Stand)	18½"L x 17"W x 26"H, 53 LBS

Capacities:

Throat Capacity (Left of Blade)	13½"
Height Capacity	6"
Table Tilt	10˚L, 45˚R
Blade Size Range	⅛"-¾"
Blade Length	92½"-93½"
Blade Speed	3000 FPM

Construction:

Table	Precision Ground Cast Iron
Wheels	Computer-Balanced Cast-Iron w/Rubber Tires
Body	Cast Iron
Rip Fence	Extruded Aluminum and Cast Iron
Wheel Covers	Pre-Formed Steel
Stand	Pre-Formed Steel
Paint	Powder Coated

Main Motor:

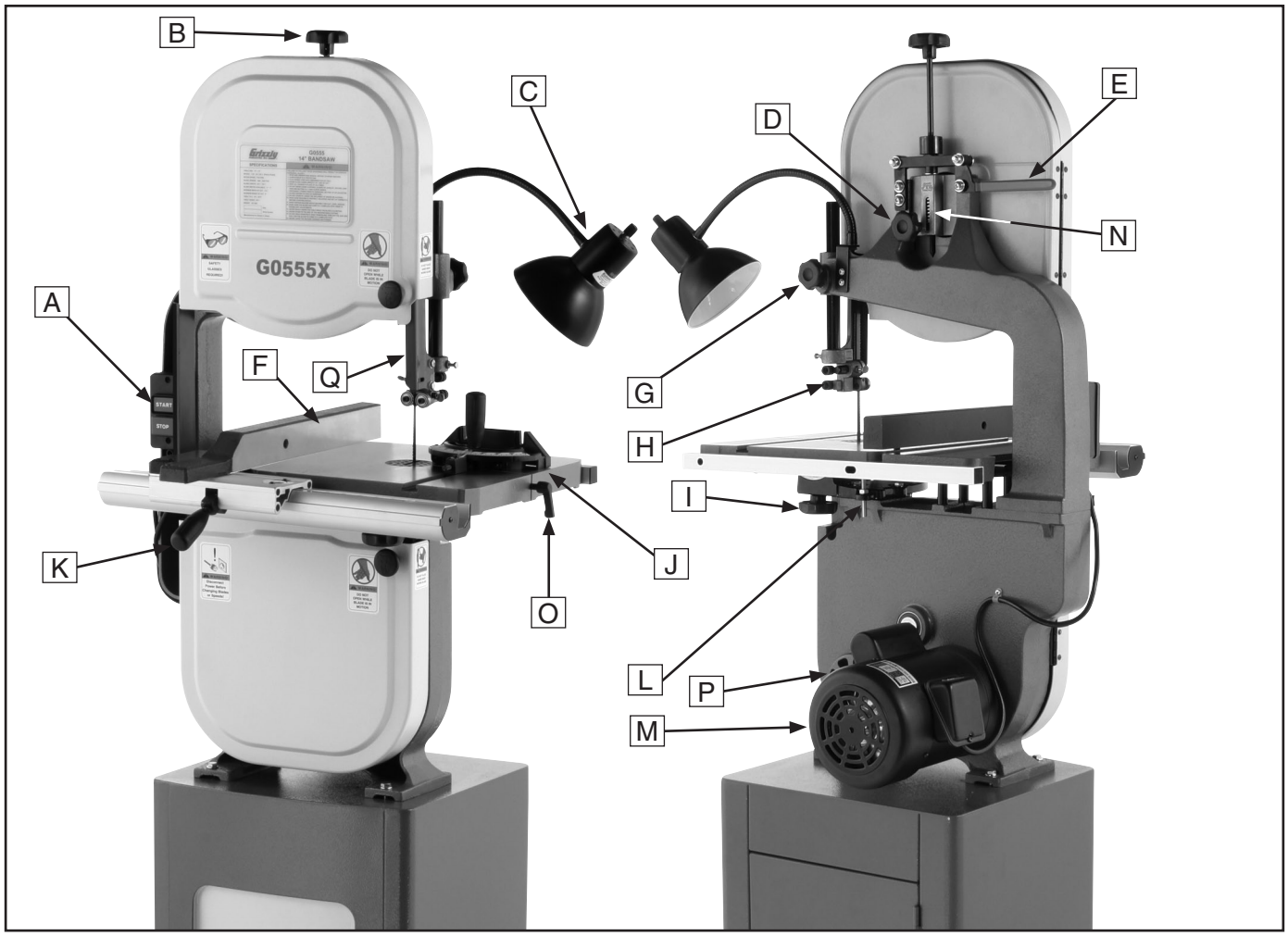
Type	TEFC Capacitor-Start Induction
Horsepower	1½ HP
Phase / Voltage	Single-Phase / 110/220V
Amps	15/7.5A
Cycle / RPM	60 Hertz / 1725 RPM
Switch	ON/OFF Push Button
Bearings	Shielded & Lubricated Ball Bearings

Features:

Included 6" High Resaw Fence Attachment
Work Light
Lower Wheel Brush
Upper & Lower Ball Bearing Blade Guides
Included Miter Gauge
Deluxe Heavy-Duty Cabinet w/Storage Shelves
Hinged Wheel Covers
4" Dust Port
6" Riser Block Available (Model H3051)
Computer-Balanced Cast-Iron Wheels
Quick Release Blade Tension

Specifications, while deemed accurate, are not guaranteed.

Identification



A. Switch
B. Blade Tension Knob
C. Work Light
D. Blade Tracking Knob
E. Quick Release Blade Tension Lever
F. Fence
G. Guide Post Lock Knob
H. Upper Blade Guide Assembly
I. Table Tilt Lock Knob
J. Miter Gauge
K. Fence Lock Handle
L. Lower Blade Guide Assembly
M. Motor
N. Blade Tension Scale
O. Table Pin
P. 4" Dust Port
Q. Blade Guard

SECTION 1: SAFETY

⚠WARNING

For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

⚠DANGER **Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.**

⚠WARNING **Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.**

⚠CAUTION **Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.**

NOTICE **This symbol is used to alert the user to useful information about proper operation of the machine.**

⚠WARNING

Safety Instructions for Machinery

1. **READ THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
2. **ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses—they are NOT safety glasses.
3. **ALWAYS WEAR A NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Wood dust can cause severe respiratory illnesses.
4. **ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing loss.
5. **WEAR PROPER APPAREL.** DO NOT wear loose clothing, gloves, neckties, rings, or jewelry that can catch in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
6. **NEVER OPERATE MACHINERY WHEN TIRED OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.

⚠WARNING
Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.

8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.

9. **MAKE WORKSHOP CHILDPROOF.** Use padlocks, master switches, and remove start switch keys.

10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power ***OFF*** and allow all moving parts to come to a complete stop before leaving machine unattended.

11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.

12. **KEEP WORK AREA CLEAN AND WELL LIGHTED.** Clutter and dark shadows may cause accidents.

13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Grounded cords minimize shock hazards. Undersized cords create excessive heat. Always replace damaged extension cords.

14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY**. Make sure switch is in OFF position before reconnecting.

15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**

17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery ***ON***.

18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding or misaligned parts, broken parts, loose bolts, and any other conditions that may impair machine operation. Repair or replace damaged parts before operation.

19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. Improper accessories increase risk of injury.

20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.

21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.

22. **DO NOT OVERREACH.** Maintain stability and balance at all times.

23. **MANY MACHINES CAN EJECT WORKPIECES TOWARD OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."

24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY**.

25. **CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Be aware of the type of dust you are exposed to and always wear a respirator designed to filter that type of dust.

⚠WARNING
Additional Safety Instructions for Bandsaws

1. **BLADE CONDITION.** Do not operate with a dull, cracked, or badly worn blade. Dull blades require more effort to use and are difficult to control. Inspect blades for cracks and missing teeth before each use.

2. **HAND PLACEMENT.** Never position fingers or thumbs in line with the cut. Serious personal injury could occur.

3. **GUARDS.** Do not operate this bandsaw without the blade guard in place.

4. **BLADE REPLACEMENT.** When replacing blades, make sure teeth face toward the workpiece and the blade is properly tensioned before operating.

5. **WORKPIECE HANDLING.** Never hold small workpieces with your fingers when cutting. Always support/feed the workpiece with push stick, table support, vise, or some type of clamping fixture.

6. **CUTTING TECHNIQUES.** Plan your cuts so you always cut out of the wood. DO NOT back the workpiece away from the blade while the saw is running. If you need to back the work out, turn the bandsaw ***OFF*** and wait for the blade to come to a complete stop, and DO NOT twist or put excessive stress on the blade while backing work away.

7. **BLADE SPEED.** Allow blade to reach full speed before cutting.

8. **LEAVING WORK AREA.** Never leave a machine running while unattended. Allow the bandsaw to come to a complete stop before leaving unattended.

9. **FEED RATE.** Always feed stock evenly and smoothly. DO NOT force or twist blade while cutting, especially when sawing tight curves.

10. **WORKPIECE MATERIAL.** This machine is designed to cut wood only—it is not designed to cut metal.

11. **MAINTENANCE/SERVICE.** Do all inspections, adjustments, and maintenance with the power ***OFF*** and the plug removed from the outlet. Wait for all moving parts to come to a complete stop.

12. **BLADE CONTROL.** Do not attempt to stop or slow the blade with your hand or a workpiece. Allow the blade to stop on its own.

13. **EXPERIENCING DIFFICULTIES.** If you experience difficulties performing the intended operation, stop using the machine and contact our Technical Support Department at (570) 546-9663.

⚠WARNING

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

⚠CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

SECTION 2: CIRCUIT REQUIREMENTS

110V/220V Operation

⚠WARNING

Serious personal injury could occur if you connect the machine to the power source before you have completed the set up process. DO NOT connect the machine to the power source until instructed to do so.

Amperage Draw

The Model G0555X features a 110V/220V motor that is prewired for 110V and draws the following amps under maximum load:

Motor Draw at 110V ..... 15 Amps
Motor Draw at 220V ..... 7.5 Amps

Circuit Requirements

We recommend connecting your machine to a dedicated and grounded circuit that is rated for the amperage given below. Never replace a circuit breaker on an existing circuit with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. **If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, consult a qualified electrician.**

110V Circuit.....20 Amps
220V Circuit.....15 Amps

Plug Type

The Model G0555X comes prewired with a NEMA 5-15 plug. If you wish to rewire the motor to 220V, we recommend using the following plug (see **Figure 1** for an example):

220V Plug & Receptacle 6-15

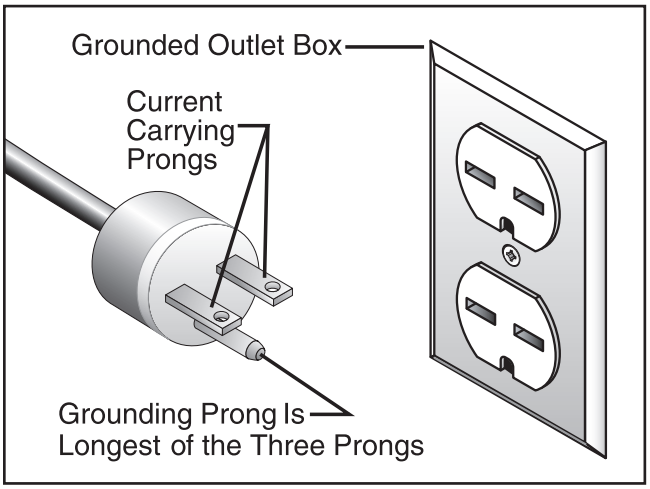
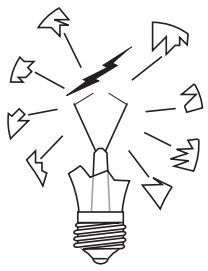


Figure 1. 6-15 plug and outlet.

NOTICE

The Model G0555X is prewired for 110V operation. If you plan to use your machine at 220V, you must rewire the motor. Refer to the wiring diagram on Page 45. Contact a qualified electrician if you do not understand basic wiring procedures.



⚠CAUTION

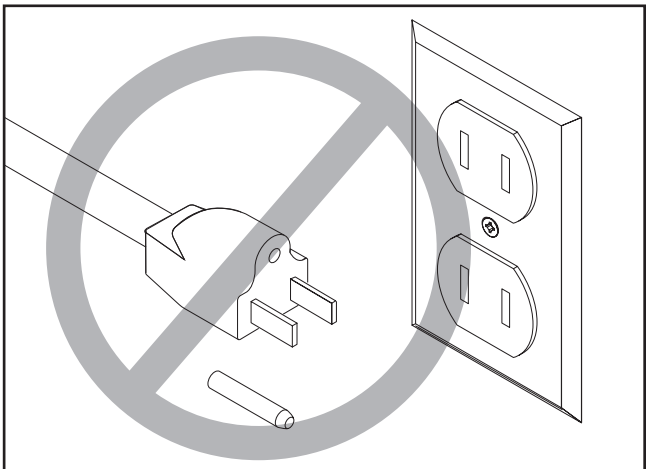
Using a bulb rated for the incorrect voltage may cause it to shatter near the operator, causing personal injury. Only use "safety coated" and shatter resistant bulbs rated for the voltage of your machine.

Grounding

In the event of an electrical short, grounding reduces the risk of electric shock. The grounding wire in the power cord must be properly connected to the grounding prong on the plug; likewise, the outlet must be properly installed and grounded. All electrical connections must be made in accordance with local codes and ordinances.

⚠WARNING

Electrocution or fire could result if this machine is not grounded correctly or if your electrical configuration does not comply with local and state codes. Ensure compliance by checking with a qualified electrician!



⚠CAUTION

This machine must have a ground prong in the plug to help ensure that it is grounded. DO NOT remove ground prong from plug to fit into a two-pronged outlet! If the plug will not fit the outlet, have the proper outlet installed by a qualified electrician.

Extension Cords

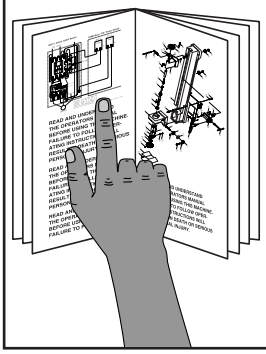
We do not recommend the use of extension cords. Instead, arrange the placement of your equipment and the installed wiring to eliminate the need for extension cords.

If you find it absolutely necessary to use an extension cord with your machine:

- The extension cord must also contain a ground wire and plug pin.
- A qualified electrician MUST size cords over 50 feet long to prevent motor damage.
- If the machine operates on 110V, use a 12 gauge cord.
- If the machine operates on 220V, use a 14 gauge cord.

SECTION 3: SET UP

Set Up Safety



WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!

WARNING

Wear safety glasses during the entire set up process!

WARNING

The Model G0555X is a heavy machine. DO NOT over-exert yourself while unpacking or moving your machine—get assistance.

Items Needed for Setup

The following items are needed to complete the setup process, but are not included with your machine:

Description	Qty
• Straightedge	1
• Level	1
• Another Person for Lifting Help	1
• Square	1
• Safety Glasses (for each person)	1
• Dust Collection System	1
• 4" Dust Hose (length as needed)	1
• 4" Hose Clamp	1

Unpacking

The Model G0555X was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, you should inventory the contents.

Inventory

After all the parts have been removed from the two boxes, you should have the following items:

Main Components: (Figure 2)	Qty
A. Stand	1
B. Bandsaw Unit	1
C. Trunnion Base	1
D. Lever Board	1
E. Miter Gauge	1
F. Extension Table	1
G. Main Table	1
H. Fence Assembly	1
I. Resaw Fence	1
J. Front Fence Rail	1
K. Rear Fence Rail	1

Fasteners and Tools: (not shown)	Qty
• Rubber Feet (Stand)	4
• Hex Nuts ⅜-16 (Feet/Stand)	8
• Flat Washers 10mm (Feet/Stand)	8
• Hex Bolts M8-1.25 x 35 (Bandsaw/Stand)	4
• Flat Washers 8mm (Bandsaw/Stand)	8
• Lock Washers 8mm (Bandsaw/Stand)	4
• Hex Nuts M8-1.25 (Bandsaw/Stand)	4
• Hex Bolts M8-1.25 x 30 (Trunnion Base)	2
• Lock Washers 8mm (Trunnion Base)	2
• Hex Bolt M8-1.25 x 80 (Positive Stop)	1
• Hex Nut M8-1.25 (Positive Stop)	1
• Spacers (Lever Board)	4
• Cap Screws M8-1.25 x 60 (Lever Board)	4
• Hex Nuts M8-1.25 (Lever Board)	4
• Set Screws M8-1.25 x 20 (Lever Board)	4
• Cap Screws M6-1 x 25 (Lever Board)	4
• Lock Washers 6mm (Lever Board)	4
• Flat Washers 6mm (Lever Board)	4
• Knobs M10-1.5 (Table)	2
• Hex Bolts M6-1 x 20 (Front Rail)	2
• Flat Washers 6mm (Front Rail)	2
• Lock Washers 6mm (Front Rail)	2
• Cap Screws M6-1 x 16 (Rear Rails)	2
• Lock Handle M8-1.25 x 20 (Fence)	1
• Hex Nut M8-1.25 (Fence)	1
• Moving Plate (Resaw)	1
• Lock Handle M8-1.25 x 44 (Resaw)	1
• Flat Washer 8mm (Resaw)	1
• Hex Wrenches 3, 4, 5mm	1 Each

If any nonproprietary parts are missing (e.g. a nut or a washer), we will gladly replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.

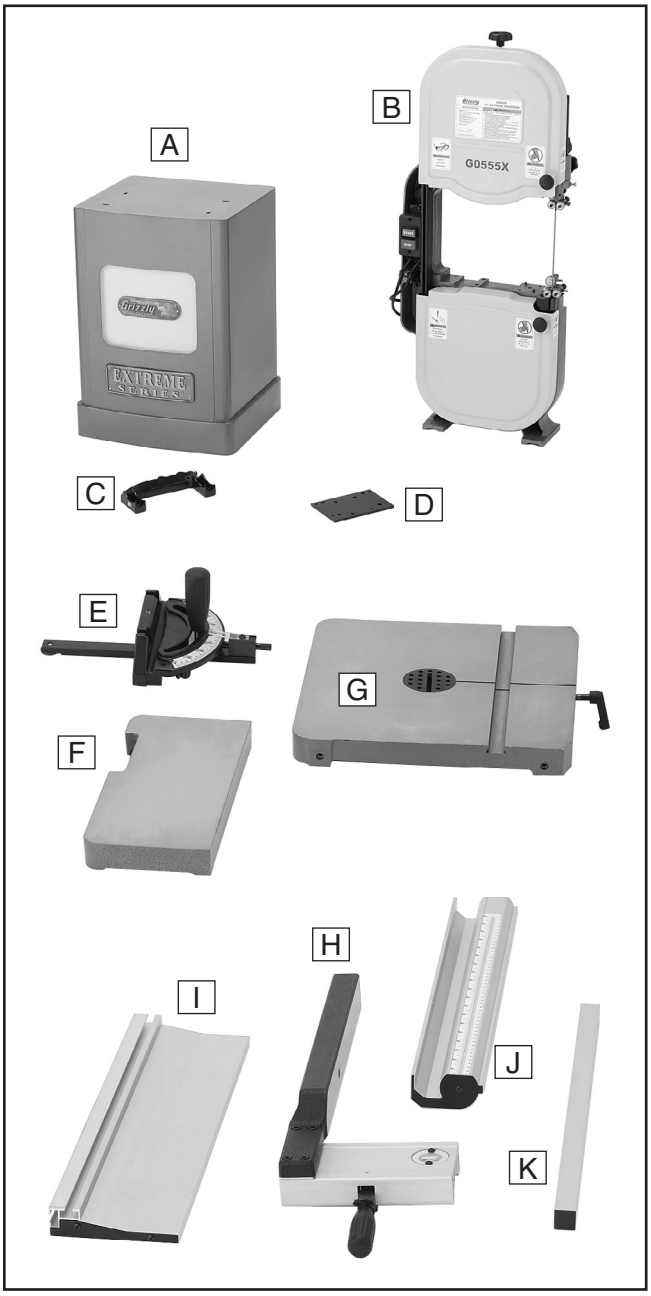
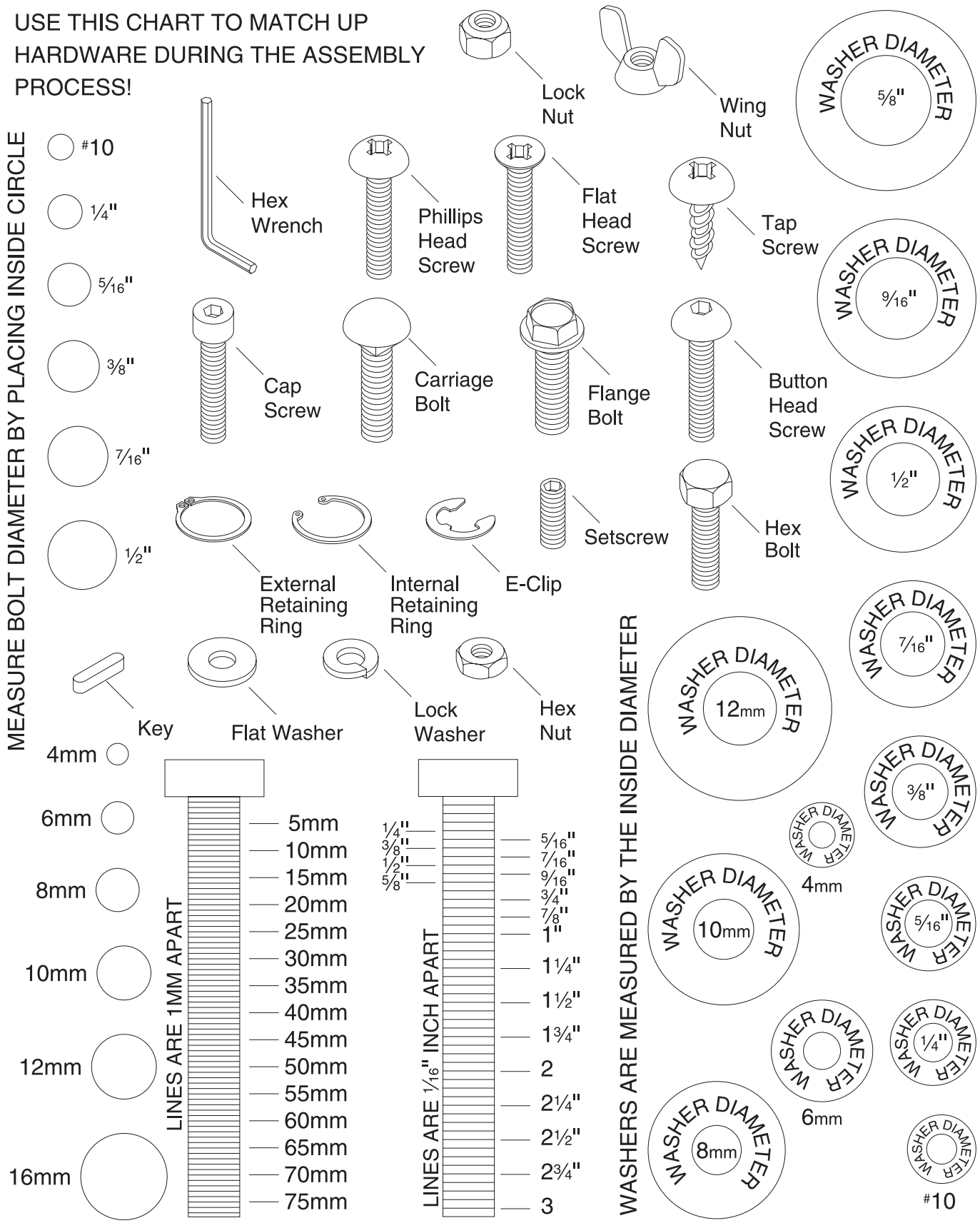


Figure 2. Main components inventory.

NOTICE

Some hardware/fasteners on the inventory list may arrive pre-installed on the machine. Check these locations before assuming that any items from the inventory list are missing.

Hardware Recognition Chart

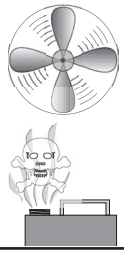


Clean Up

The unpainted surfaces are coated with a waxy oil to prevent corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts must be removed. **For optimum performance from your machine, clean all moving parts or sliding contact surfaces.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner that may damage painted surfaces. Always follow the manufacturer's instructions when using any type of cleaning product.

⚠WARNING

Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. DO NOT use these products to clean the machinery.



⚠CAUTION

Many cleaning solvents are toxic if inhaled. Minimize your risk by only using these products in a well ventilated area.

G7895—Grizzly Citrus Degreaser

This natural, citrus-based degreaser is a great solution for removing export grease, and it's much safer to work around than nasty solvents.

Figure 3. Grizzly citrus degreaser.

Site Considerations

Floor Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some residential floors may require additional reinforcement to support both the machine and operator.

Placement Location

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 4** for the minimum working clearances.

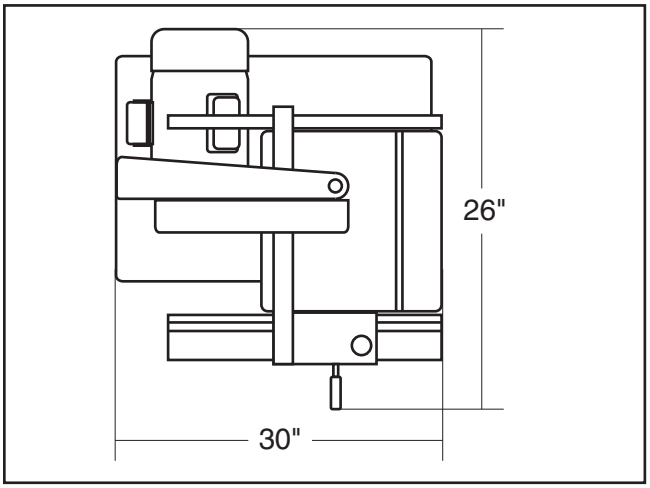
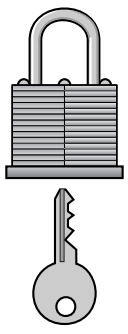


Figure 4. Minimum working clearances.



⚠CAUTION

Children and visitors may be seriously injured if unsupervised. Lock all entrances to the shop when you are away. DO NOT allow unsupervised children or visitors in your shop at any time!

Assembly

To assemble the bandsaw:

1. Install the rubber feet into the bottom of the cabinet stand, as shown in **Figure 5**, with the ⅜-16 hex nuts and 10mm flat washers.

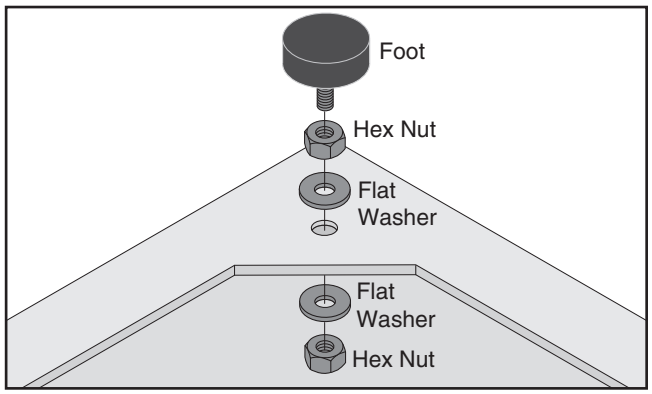


Figure 5. Rubber foot order of installation.

2. Level the cabinet stand by adjusting the feet up or down, then tighten the hex nuts against the stand to secure the feet in place.

⚠CAUTION

The bandsaw is heavy and awkward to lift. Get assistance from another person when lifting.

3. Get an assistant to help you lift the bandsaw and place it on top of the stand.

4. Line up the mounting holes on the bandsaw base with those on the stand.

5. Secure the bandsaw to the stand with the four M8-1.25 x 35 hex bolts, eight 8mm flat washers, four 8mm lock washers, and four M8-1.25 hex nuts (**Figure 6**).

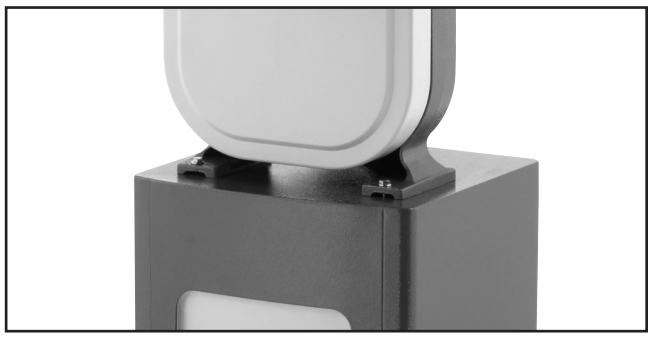


Figure 6. Bandsaw mounted to stand.

6. Fasten the trunnion base to the bandsaw, as shown in **Figure 7,** with the two M8-1.25 x 30 hex bolts and two 8mm lock washers.

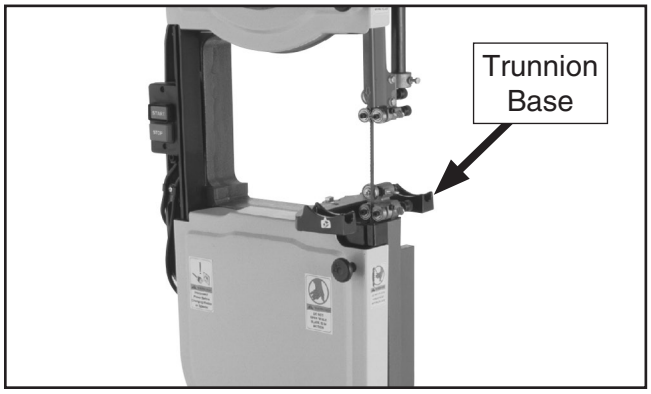


Figure 7. Installing trunnion base.

7. Thread an M8-1.25 hex nut halfway up the M8-1.25 x 80 hex bolt.

8. Thread the M8-1.25 x 80 hex bolt (a.k.a. positive stop bolt) into the trunnion base so it is installed similar to **Figure 8**.

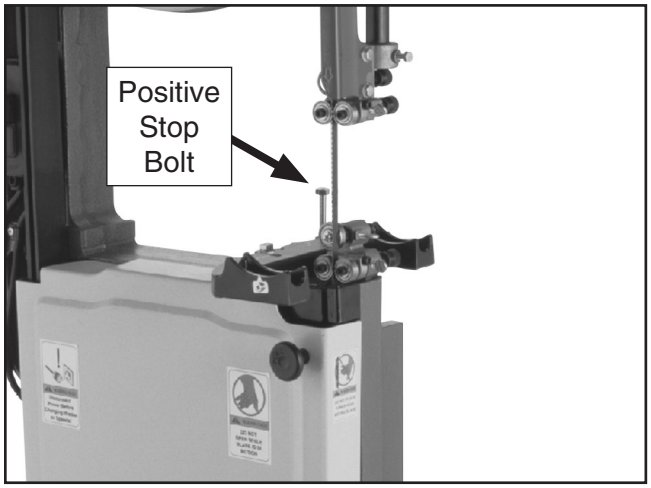


Figure 8. Shows positive stop bolt installed.

9. Attach the lever board to the bandsaw body with the four spacers and four M8-1.25 x 60 cap screws, as shown in **Figure 9**.

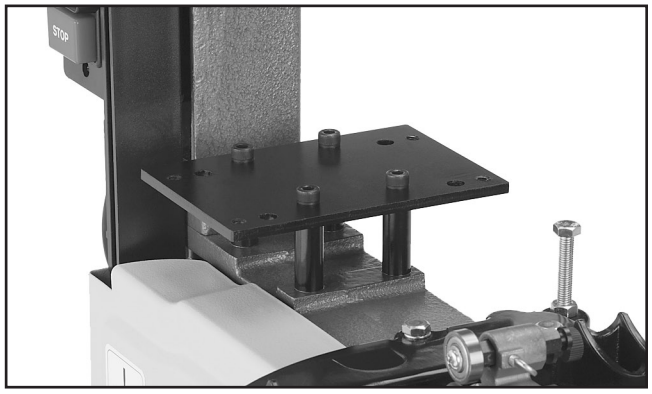


Figure 9. Lever body attached.

10. Thread the four set screws into the lever board from underneath until they are flush with the top of the lever board (**Figure 10**).

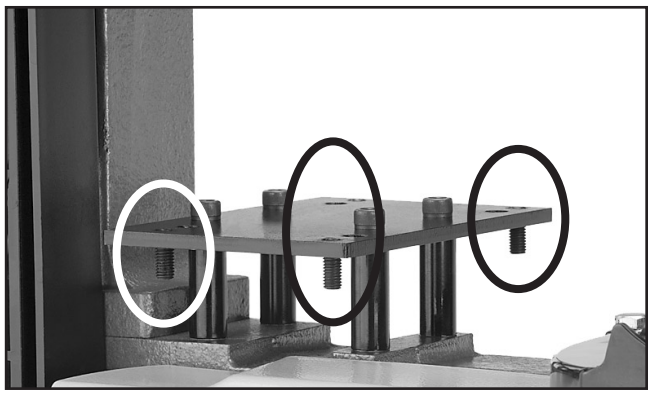


Figure 10. Set screws installed in lever board.

11. Attach the extension table to the lever board with the four M6-1 x 25 cap screws, four 6mm flat washers, and four 6mm lock washers (**Figure 11**). Only thread the cap screws in halfway for now (adjustments to the extension table will be made later).

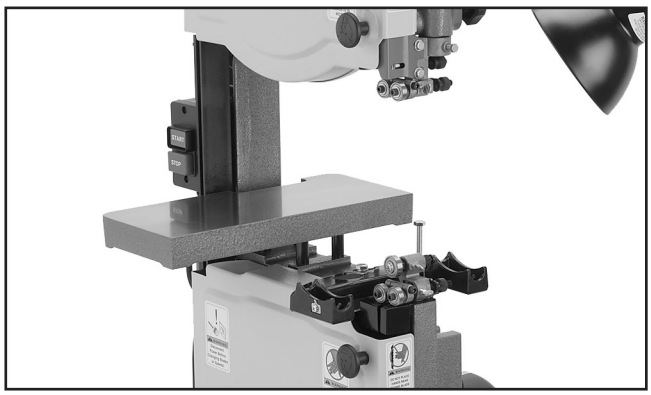


Figure 11. Extension table installed.

12. Remove the aluminum table insert from the center of the table and remove the table pin from the end of the table slot.

13. Fit the table around the blade and rest the table trunnions on the trunnion base, making sure the trunnion bolts are hanging out of the bottom of the trunnion base.

14. Thread the two M10-1.5 knobs onto the trunnion bolts hanging through the bottom of the trunnion base, as illustrated in **Figure 12**.

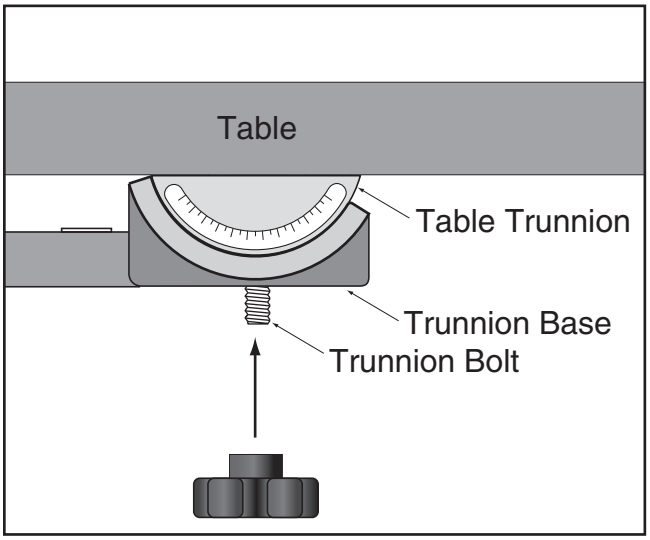


Figure 12. Table installation on trunnion base.

15. Place the table insert in the center of the table, so it sits flush with the table top surface.

16. Insert the pin into the end of the table slot.

17. Fasten the front fence rail to the front of the bandsaw table with the two M6-1 x 20 hex bolts, two 6mm lock washers, and two 6mm flat washers, as shown in **Figure 13**.

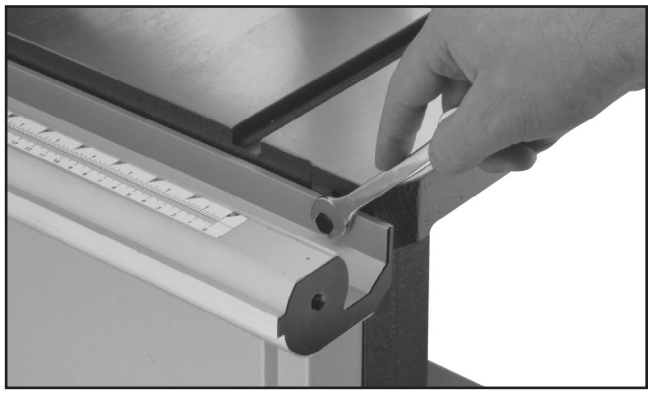


Figure 13. Fastening front fence rail to table.

18. Fasten the rear fence rail to the back of the bandsaw with two M6-1 x 16 cap screws.

19. Thread the M8-1.25 hex nut from the hardware bag onto the fence handle threads, then thread the fence handle into the fence.

20. Tighten the hex nut (already on the fence handle threads) down to the fence body to keep the fence handle from rotating.

21. Pull the fence handle up and place the fence on the front fence rail as shown in **Figure 14**.

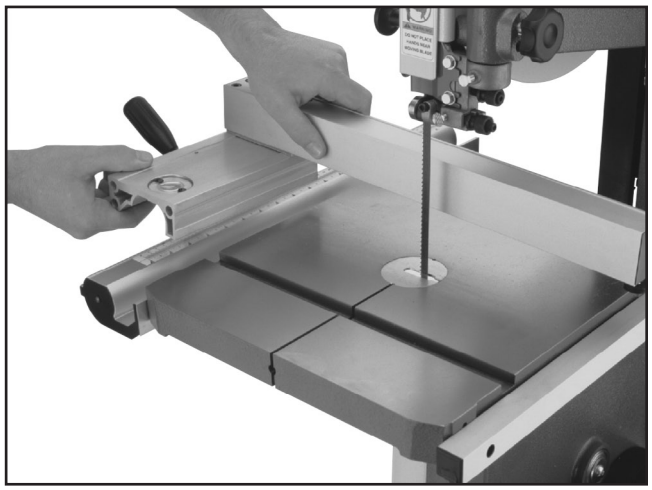


Figure 14. Installing fence onto rails.

22. Push the fence handle down to lock the fence in position.

23. Insert the lock handle with washer through the hole in the fence and attach the moving plate (**Figure 15**) on the other side.

24. Slide the resaw fence over the moving plate as shown in **Figure 15**, center it with your original fence, then lock it in position by tightening the lock handle.

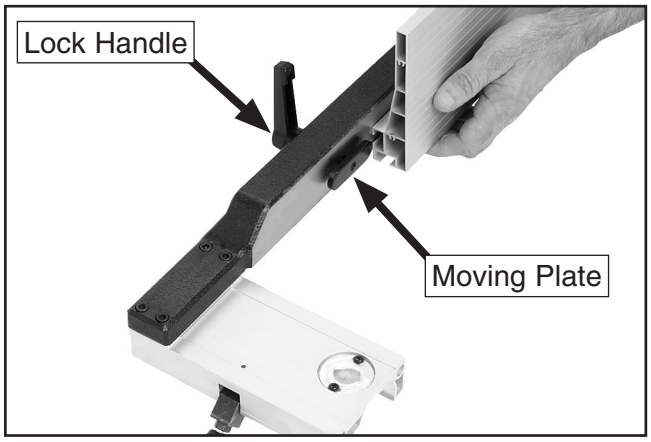
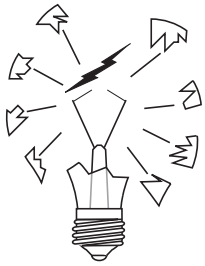


Figure 15. Installing resaw fence.

25. Install a light bulb that is rated for the wired voltage of the machine. The bulb must not exceed 60W.



⚠CAUTION

Using a bulb rated for the incorrect voltage may cause it to shatter near the operator, causing personal injury. Only use "safety coated" and shatter resistant bulbs rated for the voltage of your machine.

Dust Collection

⚠CAUTION

Only operate the Model G0555X with an adequate dust collection system. This saw creates substantial amounts of fine wood dust while operating. Failure to use a dust collection system can result in respiratory illness.

Recommended CFM at Dust Port: 400 CFM

Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To connect a dust collection hose:

1. Fit the 4" dust hose over the dust port, as shown in **Figure 16**, and secure in place with a hose clamp.

2. Tug the hose to make sure it does not come off.

   Note: *A tight fit is necessary for proper performance.*

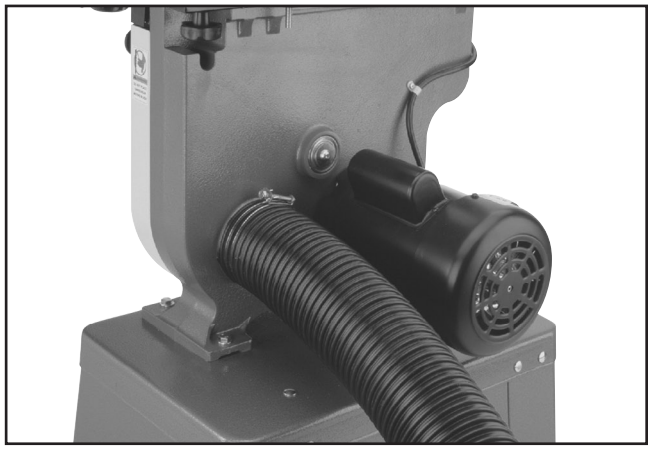


Figure 16. Dust hose attached to dust port.

Blade Tracking

"Blade Tracking" is how the blade rides on the wheels. When tracking correctly, the blade rides in the center of both wheels.

Blade tracking is primarily controlled by adjusting the upper wheel tilt. Tracking the blade in this manner is referred to as "Center Tracking," because you tilt the wheel until the blade rides in the center.

Another way to track the blade is known as "Coplanar Tracking." Coplanar tracking involves aligning the wheels so they are parallel and aligned. (See **Wheel Alignment** on **Page 41**.) When wheels are coplanar, the bandsaw decreases vibration and heat.

The wheels on the Model G0555X are factory aligned, so center tracking is the only adjustment that needs to be performed

To center track the blade:

1. DISCONNECT BANDSAW FROM POWER!

2. Adjust the upper/lower guide bearings and support bearings away from the blade.

3. Open the upper wheel cover.

4. Adjust the blade tension to match the size of the installed blade with the mark on the blade tension scale located on the back of the bandsaw.

5. Spin the upper wheel by hand at least three times and watch how the blade rides on the crown of the wheel. Refer to **Figure 17** for an illustration of this concept.

   —**If the blade rides in the center of the upper wheel and is centered on the peak of the wheel crown**, then the bandsaw is already tracked properly and no additional adjustments are needed. Skip to **Step 9**.

   —**If the blade does not ride in the center of the upper wheel and is not centered on the peak of the wheel crown,** then continue with the next step.

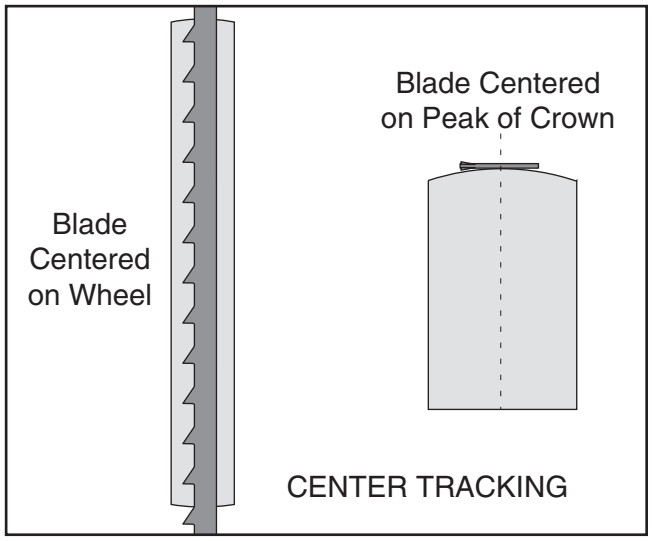


Figure 17. Center tracking profiles.

6. Loosen the lock nut on the blade tracking knob threads so the blade tracking knob will rotate for adjustments.

7. Spin the upper wheel with one hand and rotate the blade tracking knob with the other hand to make the blade ride in the center of the bandsaw wheel tire.

8. After the blade consistently rides in the center of the wheel, tighten the tracking control lock nut.

9. Close the upper wheel cover.

Note: *For the best performance from your saw, regularly maintain the proper tracking of the blade.*

NOTICE

Changes in the blade tension may change the blade tracking.

Test Run

Once the assembly is complete and you have performed the **Blade Tracking** steps on **Page 17**, you need to test run the machine to continue with the remainder of the adjustments.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop the machine immediately, then review **Troubleshooting** on **Page 36**.

If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

⚠WARNING

Wear safety glasses during the entire test run process. Failure to comply may result in serious personal injury.

To test run the machine:

1. Connect the machine to the power source.

2. Make sure that you have read the **Safety** section at the beginning of the manual and that the machine is setup properly.

3. Make sure all tools and objects used during set up are cleared away from the machine.

4. Turn the machine ***ON***.

5. Listen to and watch for abnormal noises or actions. The machine should run smoothly with little or no vibration or rubbing noises.

   —Strange or unusual noises must be investigated and corrected before operating the machine further. Always disconnect the machine from power before investigating or correcting potential problems.

Tensioning Blade

A properly tensioned blade is essential for making accurate cuts and is a prerequisite for making many bandsaw adjustments.

To tension the bandsaw blade:

1. Make sure that you have performed the **Test Run** instructions on the previous page and that the blade is tracking properly.

2. With the blade tension lever in the down (engaged) position, adjust the blade tension so the mark on the blade tension scale matches the size of blade that is installed on the bandsaw.

   Note: *Because each blade is different and all blades stretch, this scale can only be considered as a general guide.*

3. Turn the bandsaw ***ON***.

4. Release the tension one quarter of a turn at a time. Do this very slowly. When you see the bandsaw blade start to flutter, stop decreasing the tension.

5. Now, slowly increase the tension until the blade stops fluttering, then tighten the tension one more quarter of a turn.

6. Look at what the tension gauge reads and use that as a guide for tensioning that blade in the future.

   Note: *However, do not rely on this measurement for long periods of time because the blade will stretch with use.*

NOTICE

To reduce blade stretching, remove the tension from the blade when not in use.

NOTICE

After blade tension and tracking are set correctly, properly adjust the upper/lower support bearings and guide-block assemblies into position before cutting operations.

Adjusting Support Bearings

The support bearings are positioned behind the blade and support the back of the blade during cutting operations. Proper adjustment of the support bearings is an important part of making accurate cuts and also keeps the blade teeth from coming in contact with the guide bearings while cutting.

To adjust the support bearings:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.

2. DISCONNECT BANDSAW FROM POWER!

3. Familiarize yourself with the support bearing controls shown in **Figure 18**.

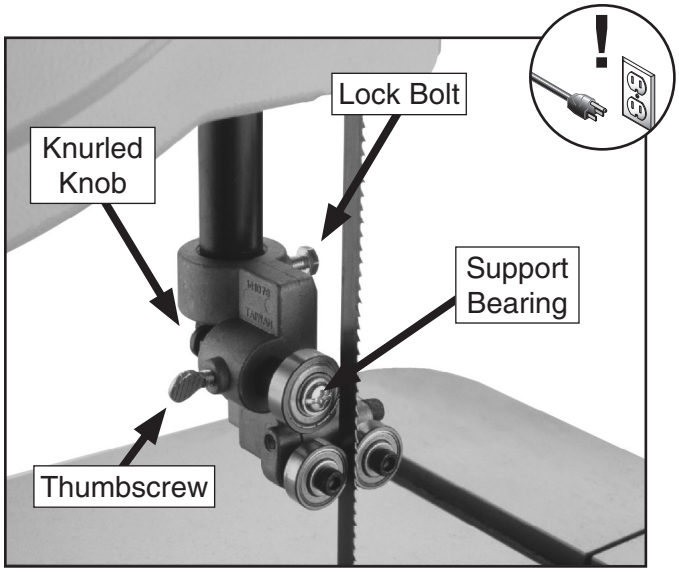


Figure 18. Support bearing controls.

4. Loosen the lock bolt shown in **Figure 18**.

5. Look at the face of the support bearing and rotate the blade guide assembly side-to-side, until the blade is perpendicular with the face of the support bearing as illustrated in **Figure 19**.

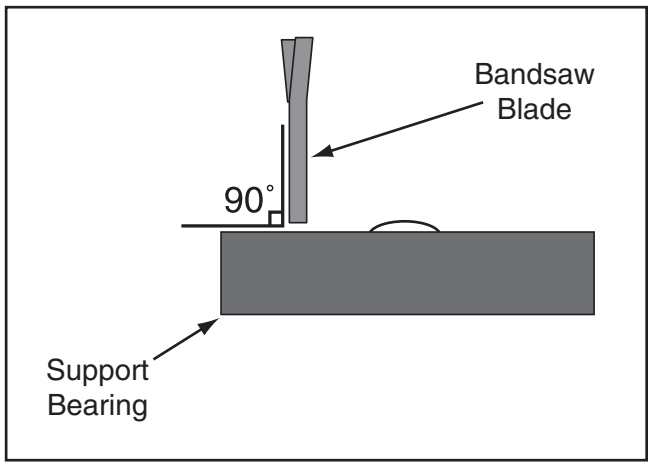


Figure 19. Blade should be perpendicular (90˚) to the face of the support bearing.

6. Tighten the lock bolt.

7. Loosen the thumbscrew on the support bearing adjustment shaft.

8. Use the knurled knob to position the support bearing approximately 0.016" away from the back of the blade as illustrated in **Figure 20**.

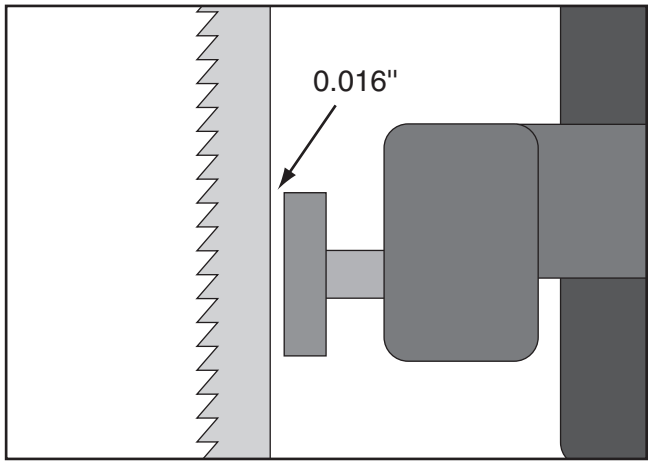


Figure 20. Blade should be aligned approximately 0.016" away from the bearing edge.

9. To quickly gauge this setting, fold a dollar bill in half twice (when folded tightly, four thicknesses of a dollar bill is approximately 0.016"). Place the folded dollar bill between the support bearing and the blade as shown in **Figure 21**.

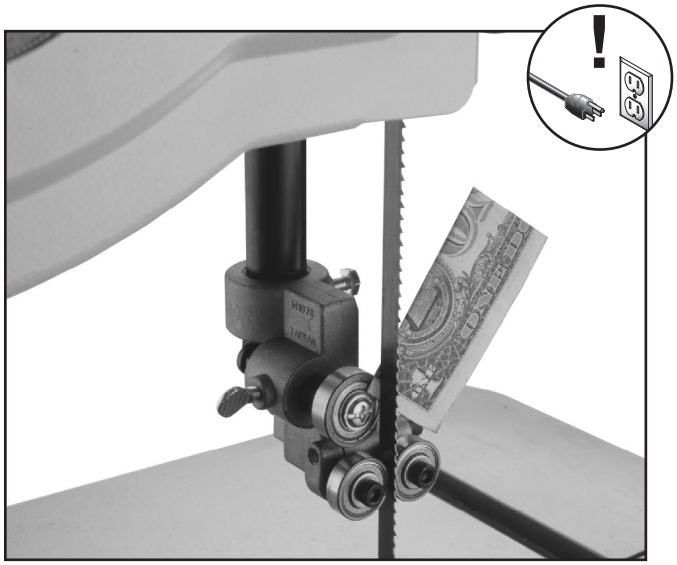


Figure 21. Dollar bill folded twice to make a quick 0.016" gauge.

10. Tighten the thumbscrew to lock the support bearing in place.

NOTICE

Whenever changing a blade or adjusting tension and tracking, the upper and lower blade support bearings and guide-blocks must be re-adjusted before cutting operations.

Adjusting Blade Guides

The blade guides provide side-to-side support to help keep the blade straight while cutting. The blade guides are designed to be adjusted in two ways—forward/backward and side-to-side. Properly adjusted blade guides are essential to making accurate cuts.

To adjust the upper and lower blade guides:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.

2. DISCONNECT BANDSAW FROM POWER!

3. Familiarize yourself with the blade guide controls shown in **Figure 22**.

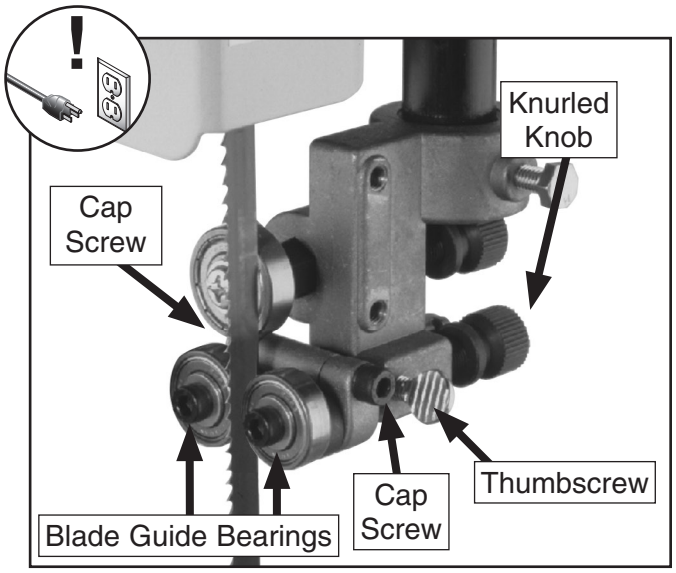


Figure 22. Blade guide controls.

4. Loosen the thumbscrew on the forward/backward adjustment rod.

5. Rotate the knurled knob behind the blade guides to position the blade guides laterally, so the front edges of the bearings are just behind the blade gullets as illustrated in **Figure 23**.

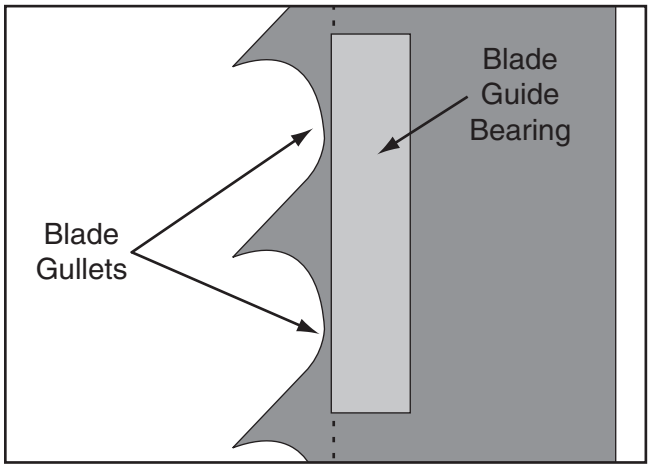


Figure 23. Lateral adjustment of blade guides.

NOTICE

Make sure that the blade teeth will not contact the guide bearings when the blade is against the rear support bearing during the cut.

6. Tighten the thumbscrew on the lateral adjustment rod so the knurled knob will not turn.

7. Use a hex wrench to loosen the cap screws behind the blade guides.

8. With a hex wrench, rotate the cap screws in the center portion of the blade guides to position the bearings so they make very light contact on both sides of the blade as illustrated in **Figure 24**.

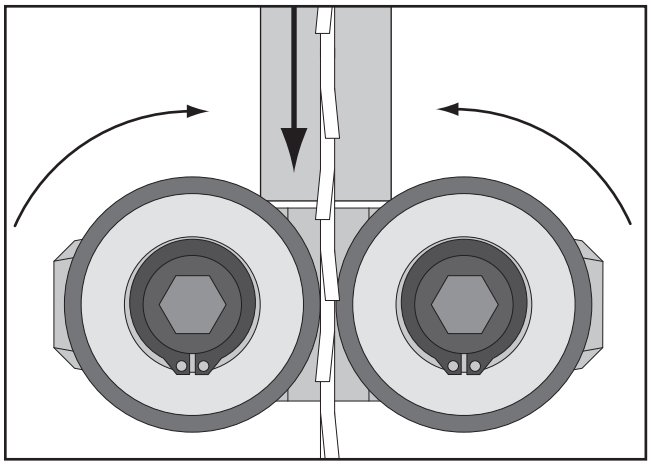


Figure 24. Blade guide bearings against both sides of blade.

NOTICE

The blade guides should only have light pressure against the blade.

9. Tighten the cap screws to lock the blade guides in position.

When the blade guide bearings are properly positioned, they rotate when the bandsaw wheel is turned and they can be rotated with your fingers when the blade is still.

NOTICE

Whenever changing a blade or adjusting tension and tracking, the upper and lower blade guide bearings and guide-blocks must be re-adjusted before cutting operations.

Adjusting Positive Stop

An adjustable positive stop allows the table to easily return to 90˚ after tilting.

To set the positive stop 90˚ to the blade:

1. Make sure the blade is correctly tensioned as described in the **Tensioning Blade** instructions on **Page 19**.

2. DISCONNECT BANDSAW FROM POWER!

3. Loosen the two plastic knobs that secure the table to the trunnions.

4. Loosen the hex nut that locks the positive stop bolt in place.

5. Raise the upper blade guide assembly and place a 6" machinist's square or try-square on the table next to the side of the blade as illustrated in **Figure 25**. Adjust the positive stop bolt to raise or lower the table until the table is 90˚ to the blade.

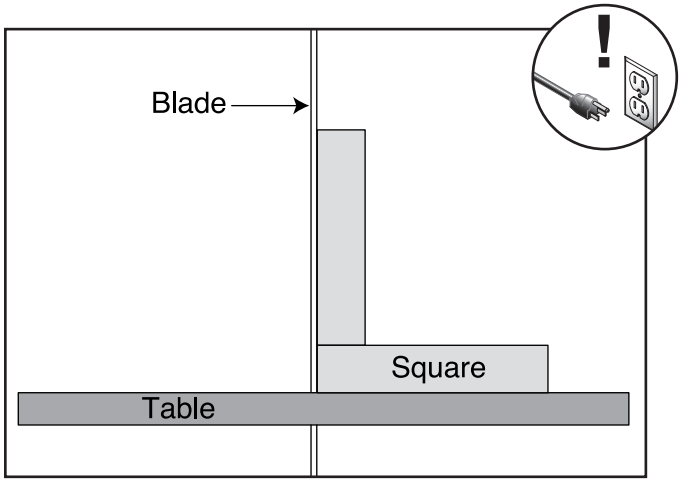


Figure 25. Squaring table to blade.

6. Secure the plastic knobs and lock the positive stop bolt by tightening the hex nut against the casting. *Ensure that the bolt does not turn by holding with another wrench while tightening the hex nut.*

Setting Table Tilt Scale to 0˚

The pointer on the table tilt scale must be calibrated in order for the scale reading to be accurate.

To calibrate the pointer on the table tilt scale:

1. Make sure that the blade is tensioned and is tracking correctly, and that the table is 90˚ to the blade (this procedure should be already completed with the **Adjusting Positive Stop** instructions).

2. Loosen the screw on the pointer so the pointer is able to move.

3. Align the tip of the pointer with the 0˚ mark on the table tilt scale.

4. Tighten the screw on the pointer so the pointer is locked in place.

Leveling Extension Table

The extension table must be level with the main table. It is important to keep the extension table at least ⅛" away from the main table during leveling to allow the table room for tilting.

To level the extension table:

1. Set the table to 90°.

2. Place a straightedge across the front of the main table and extension table as shown in **Figure 26**.

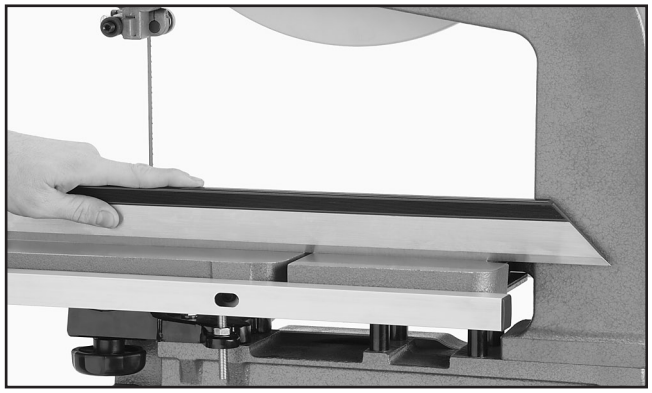


Figure 26. Leveling extension table with straightedge.

3. Adjust the two front setscrews in the lever board until the extension table is even with the main table.

4. Place a straightedge across the rear of the main table and extension table.

5. Adjust the two front setscrews in the lever board until the extension table is even with the main table.

6. Repeat **Steps 2–3**.

7. Repeat **Steps 4–5**.

8. Tighten the cap screws that secure the extension table to the lever board.

9. Verify that the extension table did not move during tightening and adjust if necessary.

Aligning Table

To ensure cutting accuracy when the table is first installed, the table should be aligned so the miter slot is parallel to the bandsaw blade. *This procedure works best with a ¾" blade.*

To align the miter slot parallel to the bandsaw blade:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.
2. DISCONNECT BANDSAW FROM POWER!
3. Loosen the trunnion bolts that secure the trunnions to the table.
4. Place an accurate straightedge along the blade. The straightedge should lightly touch both the front and back of the blade.
5. Use a fine ruler to gauge the distance between the blade and the miter slot. The distance you measure should be the same at both the front and back ends of the miter slot.
6. Adjust the table as needed until the distance between the blade and miter slot is equal at both ends, as measured in **Step 5**.
7. Tighten the trunnion bolts.

Aligning Fence

To ensure cutting accuracy, the fence must be parallel with the miter slot.

To align the fence parallel with the miter slot:

1. If the fence is mounted on the left-hand side of the blade, remove it and remount it on the right-hand side of the blade.
2. Loosen the four cap screws located on the top face of the fence.
3. Adjust the fence face parallel with the edge of the miter slot.
4. Tighten the four cap screws, being careful not to move the fence.

NOTICE

Adjusting the fence parallel to the miter slot does not guarantee straight cuts. The miter slot may need to be adjusted parallel to the side of the blade. Refer to the Aligning Table instructions.

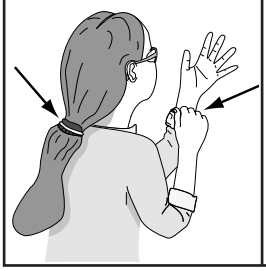
SECTION 4: OPERATIONS

Operation Safety

⚠WARNING

Damage to your eyes, lungs, and ears could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.





⚠WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing and long hair away from moving machinery.

NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Overview

The bandsaw is one of the most versatile wood cutting tools in the shop. It is capable of performing the following types of cuts:

Straight Cuts

- Miters
- Angles
- Compound Angles
- Resawing
- Ripping
- Crosscutting

Irregular Cuts

- Simple and Complex Curves
- Duplicate Parts
- Circles
- Beveled Curves

A properly adjusted bandsaw can be safer to operate than most other saws and performs many functions with ease and accuracy.

Basic Cutting Tips

Here are some basic tips to follow when operating the bandsaw:

- Replace, sharpen, and clean blades as necessary. Make adjustments periodically to keep the saw running in top condition.
- Use light and even pressure while cutting. Light contact with the blade eases line following and prevents undue friction.
- Avoid twisting the blade when cutting around tight corners. Allow the blade to saw around the corners.
- Misusing the saw or using incorrect techniques is unsafe and results in poor cuts. Remember—the blade does the cutting with the operator's guidance.

Motor & Light Switch

The motor switch is shown in **Figure 27** and is clearly marked for starting/stopping the machine.

The light switch powers the lamp independently from the motor switch. ALWAYS turn this switch ***OFF*** (the "0" position) to cut power to the lamp BEFORE changing the light bulb.

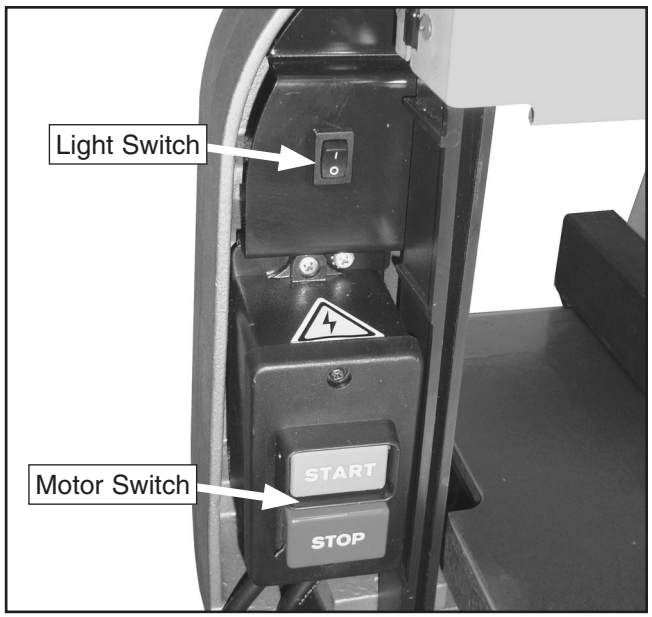


Figure 27. Motor & light switch.

Table Tilt

The bandsaw table tilts 10˚ left and 45˚ right to provide a wide range of cutting options.

To tilt the table:

1. Loosen the two table-trunnion knobs underneath the table.

2. Tilt the table to the desired angle. (Refer to the angle gauge on the front table trunnion.)

3. Retighten both table-tunnion knobs.

NOTICE

When tilting the table to the left, it is necessary to remove the positive stop.

Guide Post

The guide post (shown in **Figure 28**) connects the upper blade guide assembly to the bandsaw. The guidepost allows the blade guide assembly to move up or down to be as close to the workpiece as possible. In order to cut accurately and safely, the bottom of the blade guide assembly must be no more than 1" from the workpiece at all times—this positioning provides the greatest support to the blade and minimizes operator exposure to the blade.

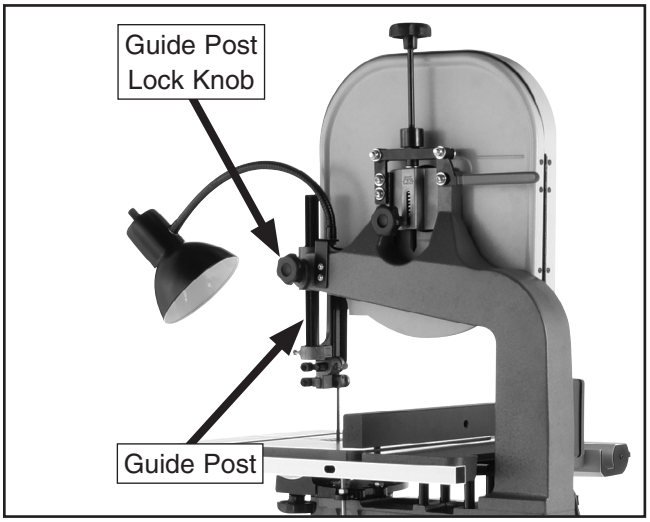


Figure 28. Guide post controls.

To adjust the blade guide assembly on the guide post (the bandsaw must be turned *OFF*):

1. Make sure that the blade tension, blade tracking, support bearing and blade guides are adjusted correctly.

2. Loosen the guide post lock knob shown in **Figure 28**.

3. Raise/lower the guide post so the bottom of the blade guide assembly is less than 1" from the top of the workpiece.

4. Lock the guide post with the lock knob.

Ripping

"Ripping" means cutting with the grain of the wood stock. For plywood and other processed wood, ripping simply means cutting down the length of the workpiece.

To make a rip cut:

1. Adjust the fence to match the width of the cut on your workpiece, then lock the fence in place.

2. Adjust the blade guide assembly to less than 1" away from the workpiece.

3. After all safety precautions have been met, turn the bandsaw ***ON***. Slowly feed the workpiece into the blade and continue with the cut until the blade is completely through the workpiece. **Figure 29** shows a typical ripping operation.

   Note: *If you cut narrow pieces, use a push stick to protect your fingers.*

Figure 29. Typical ripping operation.

⚠WARNING

NEVER place fingers or hands in the line of cut. If you slip, your hands or fingers may go into the blade. ALWAYS use a push stick when ripping narrow pieces. Failure to follow these warnings may result in serious personal injury!

Crosscutting

"Crosscutting" means cutting across the grain of wood. For plywood and other processed wood, crosscutting simply means cutting across the width of the workpiece.

To make a 90˚ crosscut:

1. Mark the workpiece on the edge where you want to begin the cut.

2. Adjust the blade guide assembly to to less than 1" away from the workpiece and make sure the miter gauge is set to 90°.

3. Move the fence out of the way. Place the workpiece evenly against the miter gauge.

4. Hold the workpiece against the miter gauge and align the mark with the blade.

5. After all safety precautions have been met, turn the bandsaw ***ON***. Slowly feed the workpiece into the blade and continue the cut until the blade is all the way through the workpiece. **Figure 30** shows a typical crosscutting operation.

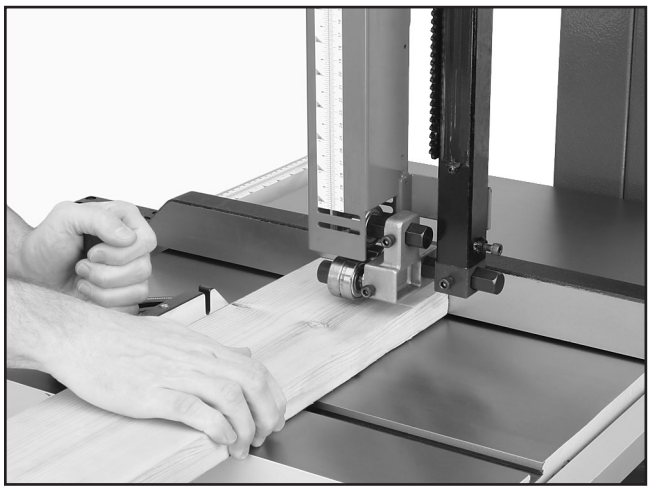


Figure 30. Typical crosscutting operation.

Resawing

"Resawing" (**Figure 31**) means cutting the thickness of a board into two or more thinner boards. The maximum board width that can be resawn is limited by the maximum cutting height of the bandsaw.

One of the most important considerations for resawing is blade selection—a wide blade cuts straighter and is less prone to blade lead (see **Page 40** for more info on blade lead).

For most applications, use a blade with a hook or a skip tooth style. Choose blades with fewer teeth-per-inch (from 3 to 6), because they offer larger gullet capacities for clearing sawdust, reducing heat buildup and reducing strain on the motor.

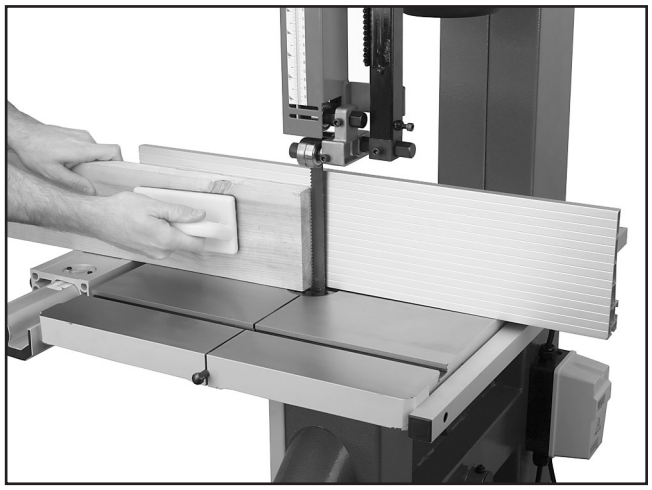


Figure 31. Typical resawing operation.

⚠WARNING

When resawing thin pieces, a wandering blade (blade lead) can tear through the side of the workpiece, exposing your hands to the blade teeth. Always use push blocks when resawing and keep your hands clear of the blade.

To resaw a workpiece:

1. Verify that the bandsaw is setup properly and that the table is perpendicular to the blade.

2. Use the widest blade your bandsaw will accept. **Note:** *The blade must also be sharp and clean.*

3. Install the resaw fence, adjust it to the desired width of cut, and lock it in place.

NOTICE

The scale on the front rail will NOT be accurate when using the resaw fence.

4. Support the ends of the board if necessary.

5. Turn the bandsaw ***ON***.

6. Using push paddles and a push stick, maintain workpiece pressure against the fence and table, and slowly feed the workpiece into the moving blade until the blade is completely through the workpiece (see **Figure 31**).

Cutting Curves

When cutting curves, simultaneously feed and turn the stock carefully so the blade follows the layout line without twisting. If a curve is so abrupt that it is necessary to repeatedly back up and cut a new kerf, use a narrower blade, a blade with more TPI (teeth per inch), or more relief cuts.

Relief cuts are cuts made through the waste portion of the workpiece and are stopped at the layout line. Relief cuts reduce the chance that the blade will be pinched or twisted by removing waste wood from the workpiece and alleviating any pressure on the back of the blade.

NOTICE

The list below shows the minimum radii for different blade widths.

Width	Radius
1/8"	1/8"
3/16"	3/8"
1/4"	5/8"
3/8"	1 1/4"
1/2"	2 1/2"
5/8"	3 3/4"
3/4"	5 1/2"

Stacked Cuts

One of the benefits of a bandsaw is its ability to cut multiple copies of a particular shape by stacking workpieces together and cutting them as one. Before making stacked cuts, ensure that both the table and the blade are properly adjusted to 90°; otherwise, any error will be compounded.

To complete a stacked cut:

1. Align your pieces from top-to-bottom to ensure that each piece has adequate scrap to provide a clean, unhampered cut.

2. Secure all the pieces together in a manner that will not interfere with the cutting. Hot glue on the edges works well, as do brad nails through the waste portion. (Be careful not to cut into the brads or you may break the blade!)

3. On the face of the top piece, mark the shape you intend to cut.

4. Make relief cuts perpendicular to the outline of your intended shape in areas where changes in blade direction could cause the blade to bind.

5. Cut the stack of pieces as though you were cutting a single piece. Follow your layout line with the blade kerf on the waste side of your line as shown in **Figure 32**.

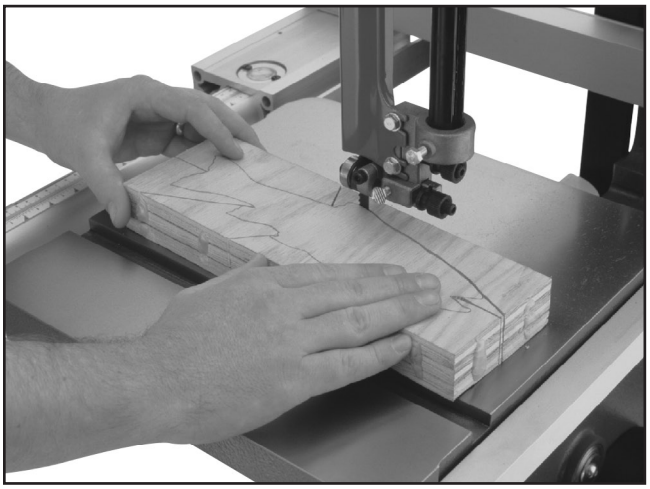


Figure 32. Typical stacked cut.

Blade Information

Selecting the right blade requires a knowledge of various blade characteristics to match the blade with the particular cutting operation.

Blade Length

Measured by the circumference, blade lengths are usually unique to the brand of your bandsaw and the distance between wheels. The Model G0555X is designed for blades that are 93½" long. Refer to **Page 31** for blade replacements.

Blade Width

Measured from the back of the blade to the tip of the blade tooth (the widest point), blade width is often the first consideration given to blade selection. Blade width dictates the largest and smallest curve that can be cut, as well as how accurately it can cut a straight line.

The Model G0555X uses blades from ⅛" to ¾" in width. Always pick the size of blade that best suits your application.

- ***Curve Cutting:*** Use the chart in **Figure 33** to determine the correct blade for curve cutting. Determine the smallest radius curve that will be cut on your workpiece and use the corresponding blade width.

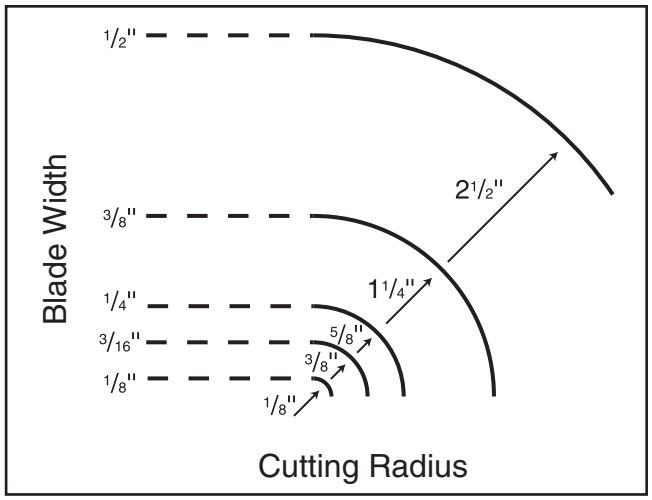


Figure 33. Blade width radii.

- ***Straight Cutting*:** Use the largest width blade that you own. Narrow blades can cut tight curves (a small radius) but are not very good at cutting straight lines because they naturally wander (blade lead). However, large blades excel at cutting straight lines, but function poorly at cutting small curves because of their size.

Tooth Style

When selecting blades, another option to consider is the shape, gullet size, teeth set and teeth angle—otherwise known as "Tooth Style."

Figure 34 illustrates the three main categories of tooth style:

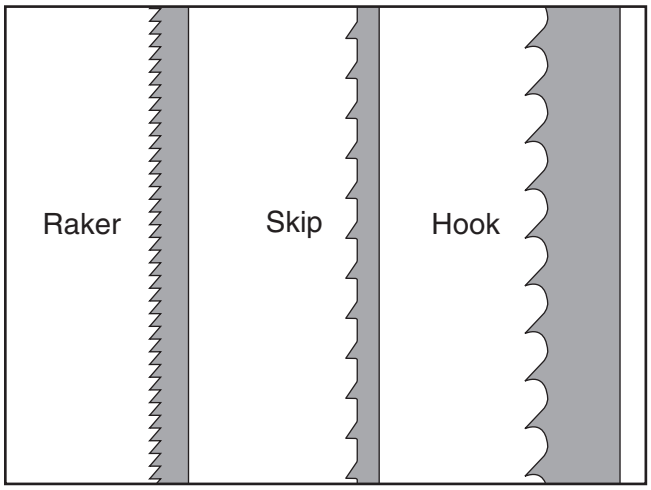


Figure 34. Raker, Skip & Hook tooth styles.

- ***Raker*:** This style is considered to be the standard because the tooth size and shape are the same as the tooth gullet. The teeth on raker blades usually are very numerous, have no angle, and produce cuts by scraping the material; these characteristics result in very smooth cuts, but do not cut fast and generate more heat while cutting.

- ***Skip*:** This style is similar to a raker blade that is missing every other tooth. Because of the design, skip toothed blades have a much larger gullet than raker blades, and therefore, cut faster and generate more heat. However, these blades also leave a rougher cut than raker blades.

- ***Hook***: The teeth on this style have a positive angle (downward) which makes them dig into the material, and the gullets are usually rounded for easier waste removal. These blades are excellent for the tough demands of resawing and ripping thick material.

Tooth Pitch

Usually measured as TPI (teeth per inch), tooth pitch determines the size of the teeth. More teeth per inch (fine pitch) will cut slower, but smoother; while fewer teeth per inch (coarse pitch) will cut rougher, but faster. As a general rule, choose blades that will have at least three teeth in the material at all times. Use fine pitched blades on harder woods and coarse pitched blades on softer woods.

Blade Care

A bandsaw blade is a delicate piece of steel that is subjected to tremendous strain. You can obtain longer use from a bandsaw blade if you give it fair treatment and always use the appropriate feed rate for your operation.

Be sure to select blades with the proper width, style, and pitch for each application. The wrong choice of blades will often produce unnecessary heat which will shorten the life of your blade.

A clean blade will perform much better than a dirty blade. Dirty or gummed up blades pass through the cutting material with much more resistance than clean blades. This extra resistance also causes unnecessary heat.

Blade Breakage

Many conditions may cause a bandsaw blade to break. Blade breakage is unavoidable, in some cases, since it is the natural result of the peculiar stresses that bandsaw blades must endure. Blade breakage is also due to avoidable circumstances. Avoidable breakage is most often the result of poor care or judgement on the part of the operator when mounting or adjusting the blade or support guides.

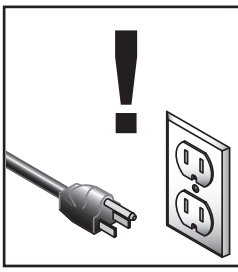
The most common causes of blade breakage are:

- Faulty alignment/adjustment of the guides.
- Forcing or twisting a wide blade around a short radius.
- Feeding the workpiece too fast.
- Dull teeth or damaged tooth sufficient set.
- Overtensioned blade.
- Top blade guide assembly set too high above the workpiece.
- Using a blade with a lumpy or improperly finished braze or weld.
- Continuously running the bandsaw when not in use.
- Leaving blade tensioned when not in use.

Grizzly Bandsaw Blades

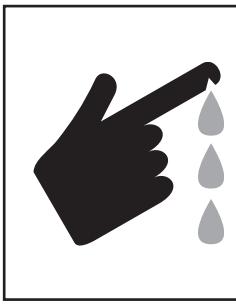
MODEL	LENGTH	WIDTH	TPI	GAUGE
G5151	93½"	1/16"	24 Raker	0.025
G5152	93½"	1/8"	14 Raker	0.025
G5153	93½"	1/8"	18 Raker	0.025
G5154	93½"	3/16"	4 Skip	0.025
G5155	93½"	3/16"	10 Raker	0.025
G5156	93½"	3/16"	14 Raker	0.025
G5157	93½"	1/4"	4 Hook	0.025
G5158	93½"	1/4"	6 Hook	0.025
G5159	93½"	1/4"	10 Raker	0.025
G5160	93½"	1/4"	14 Raker	0.025
G5161	93½"	1/4"	18 Raker	0.025
G5162	93½"	3/8"	4 Hook	0.025
G5163	93½"	3/8"	6 Hook	0.025
G5164	93½"	3/8"	10 Raker	0.025
G5165	93½"	3/8"	14 Raker	0.025
G5166	93½"	1/2"	3 Hook	0.025
G5167	93½"	1/2"	4 Hook	0.025
G5168	93½"	1/2"	6 Hook	0.025
G5169	93½"	1/2"	10 Raker	0.025
G5170	93½"	1/2"	14 Raker	0.025
G5171	93½"	3/4"	3 Hook	0.025
G5172	93½"	3/4"	6 Hook	0.025
G5173	93½"	3/4"	10 Raker	0.025

Blade Changes



⚠WARNING

Always disconnect power to the machine when changing blades. Failure to do this may result in serious personal injury.



⚠CAUTION

All saw blades are dangerous and may cause personal injury. To reduce the risk of being injured, wear leather gloves when handling saw blades.

To remove the blade:

1. DISCONNECT BANDSAW FROM POWER!
2. Release the tension lever.
3. Remove the table insert and the table pin. Adjust the upper and lower guide blocks away from the blade.
4. Open the upper and lower wheel covers and slide the blade off both wheels.
5. Rotate the blade 90˚ and slide it through the slot in the table.

To replace the blade:

1. Slide the blade through the table slot, ensuring that the teeth are pointing down toward the table. *If the teeth will not point downward in any orientation, the blade is inside-out. Put on heavy gloves, remove the blade, and twist it rightside-out.*
2. Slip the blade through the guides, and mount it over the upper and lower wheels.
3. Apply tension. If the blade cannot be tensioned as described on **Page 19**, adjust the tensioner as described in **Steps 4-6**. If the tension is correct, go to **Step 7**.

   Note: *The tensioner must be adjusted if you are using a different length of blade.*

Continued on next page ⟶

4. Remove the setscrew in the spacer indicated in **Figure 35**, and rotate the spacer up 5-6 turns.

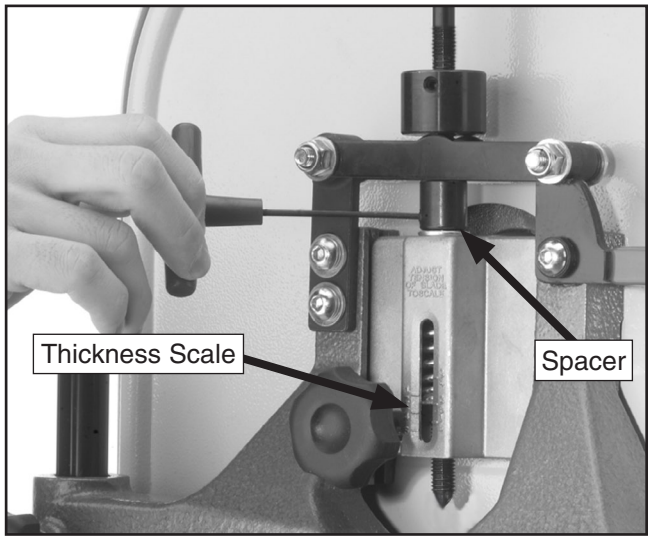


Figure 35. Tensioner adjustment.

5. Turn the tension knob until proper blade tension has been reached according to the blade thickness scale on the sliding bracket and fine tune as needed.

6. Thread the spacer down until it slightly contacts the top of the sliding bracket. Move the spacer back up the shaft about 1-2 turns to leave a small space. Replace the setscrew in the spacer and tighten (**Figure 35**).

7. Check and adjust the tracking.

8. Adjust the upper/lower guide blocks and the support bearings.

9. Close the wheel covers.

10. Replace the table insert and table pin, being sure not to use excessive force when inserting the table pin.

Scale Calibration

You may need to recalibrate the fence scale after changing or adjusting the blade, or if the scale is not producing accurate cuts. Recalibrate the fence scale by adjusting the hairline indicator on the fence and testing your adjustment by cutting a piece of scrap wood.

To calibrate the scale:

1. Set the fence anywhere along the scale and locate a piece of scrap wood with at least one straight edge. *Joint the edge with a jointer if needed to make the edge straight.*

2. Hold the straight edge of the workpiece firmly against the fence, and feed the workpiece through the saw blade with a push stick.

3. Measure the width of the cut workpiece. The width of the workpiece should match the reading on the fence scale.

4. If the reading on the scale is not the same as the width of the cut workpiece, loosen the screws on the magnifying window (**Figure 36**) and adjust it to match the width of the cut workpiece.

5. Tighten the screws; the scale is now correctly calibrated.

Figure 36. Scale recalibration screws.

SECTION 5: ACCESSORIES

6" Extension Block Kit - H3051
Increase your cutting capacity from 6" to 12" cutting height with this bolt-on 6" extension block kit. Includes all necessary hardware plus extended blade guard and 105" x ⅜" x 6 TPI blade. *We also carry a full line of 105" blades!*

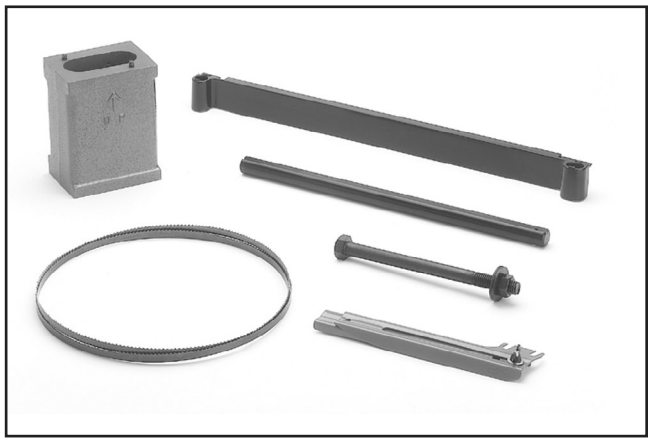


Figure 37. H3051 Extension Block Kit.

G7314—Heavy-Duty SHOP FOX® Mobile Base
Make your machine mobile with this popular patented mobile base. The unique outrigger-type supports increase stability and lower machine height. This heavy duty mobile base is rated for up to a 600 lb. capacity.

Figure 38. G7314 SHOP FOX® Mobile Base.

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 12 oz Spray
G2871—Boeshield® T-9 12 oz Spray
G2870—Boeshield® T-9 4 oz Spray
H3788—G96® Gun Treatment 12 oz Spray
H3789—G96® Gun Treatment 4.5 oz Spray

Figure 39. Recommended lubricants for protecting unpainted cast iron/steel part on machinery.

G1928—Bandsaw Handbook
This is the bandsaw bible. Covers step-by-step instructions for basic/advanced cutting techniques. Also includes advanced maintenance, service and troubleshooting procedures, as well as information on bandsaw history/design and blade metallurgy. 320 pages.

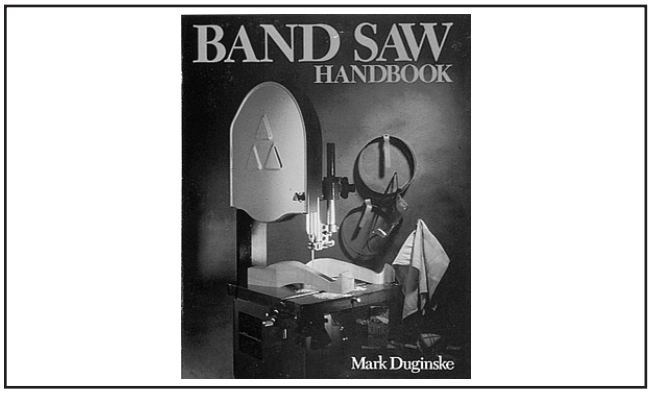
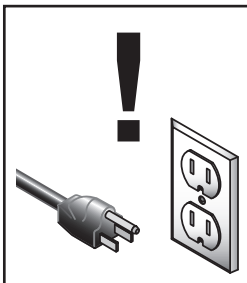


Figure 40. Bandsaw handbook.

Call 1-800-523-4777 To Order

SECTION 6: MAINTENANCE



⚠WARNING

Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury.

Schedule

For optimum performance from your machine, follow this maintenance schedule:

Daily

- Check/correct loose mounting bolts.
- Check/correct damaged saw blade.
- Check/correct worn or damaged wires.
- Correct any other unsafe condition.

Monthly

- Check for V-belt tension, damage, or wear.
- Remove blade and thoroughly clean all built-up sawdust from the rubber tires on the wheels.
- Clean/vacuum dust buildup from inside cabinet and off motor.

Cleaning

Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If resin has built up, use a resin dissolving cleaner to remove it.

Once a month, remove the blade and thoroughly clean all built-up sawdust from the rubber tires on the wheels.

Lubricating

Protect the unpainted cast iron surfaces on the table by wiping the table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Keep tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 on **Page 34**.

If the table becomes difficult to tilt, remove it and lubricate the trunnions and the slides in the trunnion base.

Redressing Rubber Tires

As the bandsaw ages, the rubber tires may need to be redressed if they harden or glazed over. Redressing the rubber tires improves blade tracking and reduces vibration/blade lead.

If the rubber tires become too worn, then blade tracking will become extremely difficult. At that point, redressing will no longer be effective and the rubber tires must be replaced.

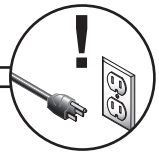
To redress the rubber tires:

1. DISCONNECT BANDSAW FROM POWER!
2. Put on heavy leather gloves.
3. Remove the blade.
4. Clean any built-up sawdust from the rubber tires.
5. Hold 100 grit sandpaper against the rubber tire and rotate the wheel by hand. Only redress the rubber enough to expose a fresh rubber surface.

SECTION 7: SERVICE

Review the troubleshooting and procedures in this section to fix or adjust your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

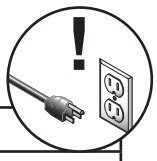
Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	1. Power supply is at fault/switched OFF.	1. Ensure hot lines have correct voltage on all legs and main power supply is switched ON.
	2. Plug/receptacle is at fault or wired incorrectly.	2. Test for good contacts; correct the wiring.
	3. Wiring is open/has high resistance.	3. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary.
	4. Motor connection wired incorrectly.	4. Correct motor wiring connections.
	5. Motor ON button or ON/OFF switch is at fault.	5. Replace faulty ON button or ON/OFF switch.
	6. Start capacitor is at fault.	6. Test/replace if faulty.
	7. Motor centrifugal switch is at fault.	7. Adjust/replace the centrifugal switch if available.
Machine stalls or is underpowered.	1. Wrong workpiece material (wood).	1. Use wood with correct moisture content, without glues, and little pitch/resin.
	2. Feed rate too fast for task.	2. Decrease feed rate.
	3. Belt slipping.	3. Tighten/repair/replace.
	4. Motor connection is wired incorrectly.	4. Correct motor wiring connections.
	5. Plug/receptacle is at fault.	5. Test for good contacts; correct the wiring.
	6. Motor bearings are at fault.	6. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
	7. Motor has overheated.	7. Clean off motor, let cool, and reduce workload.
	8. Motor is at fault.	8. Test/repair/replace.
	9. Centrifugal switch is at fault.	9. Adjust/replace centrifugal switch if available.
Machine has vibration or noisy operation.	1. Motor or component is loose.	1. Inspect/replace stripped or damaged bolts/nuts, use thread locking fluid, and retighten.
	2. Belt(s) worn or loose.	2. Tension belt (refer to **Page 38**) or replace belt (refer to **Page 39**).
	3. Motor fan is rubbing on fan cover.	3. Replace dented fan cover; replace damaged fan.
	4. Pulley is loose.	4. Tighten pulley set screw.
	5. Machine is incorrectly mounted or sits unevenly on floor.	5. Tighten/replace anchor studs in floor; relocate/shim machine.
	6. Blade is at fault.	6. Replace blade.
	7. Cast iron motor mount loose/broken.	7. Tighten/replace.
	8. Centrifugal switch.	8. Replace centrifugal switch.
	9. Motor or spindle bearings are at fault.	9. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

Cutting Operations



Symptom	Possible Cause	Possible Solution
Machine slows when operating.	1. Feeding workpiece too fast. 2. Blade is dull.	1. Reduce feed rate. See **Basic Cutting Tips** on **Page 25**. 2. Replace blade (**Page 32**).
Ticking sound when the saw is running.	1. Blade weld contacting guide/support bearings (a light tick is normal). 2. Blade weld may be failing.	1. Use file or stone to smooth and round the back of the blade; slightly loosen the blade guides. 2. Inspect and replace blade if necessary (**Page 32**).
Blade contacting table insert.	1. Insert installed upside down or backwards. 2. Table improperly mounted or aligned.	1. Re-install insert a different way. 2. Align table (**Page 24**).
Vibration when cutting.	1. Loose or damaged blade. 2. Sawdust buildup on wheels.	1. Tighten or replace blade (**Page 32**). 2. Clean all sawdust from rubber tires on wheels.
Burn marks on the edge of the cut.	1. Too much side pressure when feeding workpiece; blade is binding. 2. Blade too wide for size of radius being cut.	1. Feed workpiece straight into the blade. See **Basic Cutting Tips** on **Page 25**. 2. Install a smaller width blade/increase blade tension. See **Page 32 or 19**.
Rough or poor quality cuts.	1. Feeding workpiece too fast. 2. Blade guides adjusted incorrectly.	1. Reduce feed rate. See **Basic Cutting Tips** on **Page 25**. 2. Re-adjust all blade guides and support bearings.
Sawdust buildup inside cabinet.	1. Clogged dust port. 2. Low CFM (airflow) from dust collection system.	1. Clean out dust port. 2. Three options: —Check dust lines for leaks or clogs. —Move dust collector closer to saw. —Install a more powerful dust collector.
Blade wanders or doesn't cut straight.	1. Blade lead. 2. Sawdust buildup on wheels.	1. Refer to Blade Lead on **Page 40**. 2. Clean all sawdust from rubber tires on wheels.
Cuts are not square (vertically).	1. Table tilt is not adjusted to 0˚ or positive stop has moved out of adjustment. 2. Table tilt scale pointer is not calibrated. 3. Table is not square to the blade.	1. Adjust table tilt to 0˚; readjust positive stop if necessary (**Page 22**). 2. Calibrate table tilt scale pointer to 0˚ (**Page 22**). 3. Shim table (**Page 40**).

Miscellaneous

Symptom	Possible Cause	Possible Solution
Quick-release mechanism has poor range of motion.	1. Spacer blocks on quick-release tension mechanism have moved out of adjustment.	1. Readjust the quick-release spacer blocks (**Page 43**).
Blade tension scale is grossly inaccurate.	1. The spring in the blade tension mechanism has lost its "spring." This is caused by not releasing the blade tension when not in use or frequently over-tensioning the bandsaw.	1. Replace spring in the blade tension mechanism, then take better care of the bandsaw by releasing tension when not in use and not over-tensioning the blade.
Wheel is noisy.	1. Wheel bearing is worn out. 2. Belt is too tight (lower wheel).	1. Replace the wheel bearing. 2. Check/loosen the belt tension (**Page 38**).
Blade does not track consistently, correctly, or at all.	1. Wheels are not coplanar or aligned with each other. 2. Rubber tires on wheels are worn out.	1. Adjust wheels to be coplanar/aligned with each other (**Page 41**). 2. Redress the rubber tires on the wheels (**Page 35**); replace the rubber tires on the wheels.

Checking Belt

To ensure optimum power transfer from the motor to the blade, the belt must be in good condition and operate under proper tension. The belt should be replaced if has for cracks, fraying, or excessive wear. Belt tension should be checked at least every 3 months—more often if the bandsaw is used daily.

To check the belt:

1. DISCONNECT BANDSAW FROM POWER!

2. Open the lower wheel cover.

3. Check the belt tension. When tensioned correctly, the middle of the belt will deflect approximately ¼" when pushed with moderate pressure (see **Figure 41**).

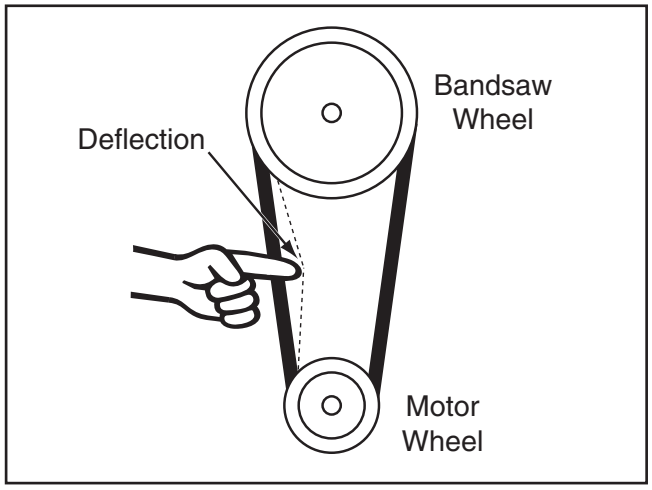


Figure 41. Belt deflection.

4. Note the condition of the belt. If the belt is cracked, frayed, or glazed; it should be replaced as soon as convenient.

Tensioning Belt

To tension the belt:

1. DISCONNECT BANDSAW FROM POWER!

2. Open the lower wheel cover.

3. Loosen the motor mount bolts shown in **Figure 42**.

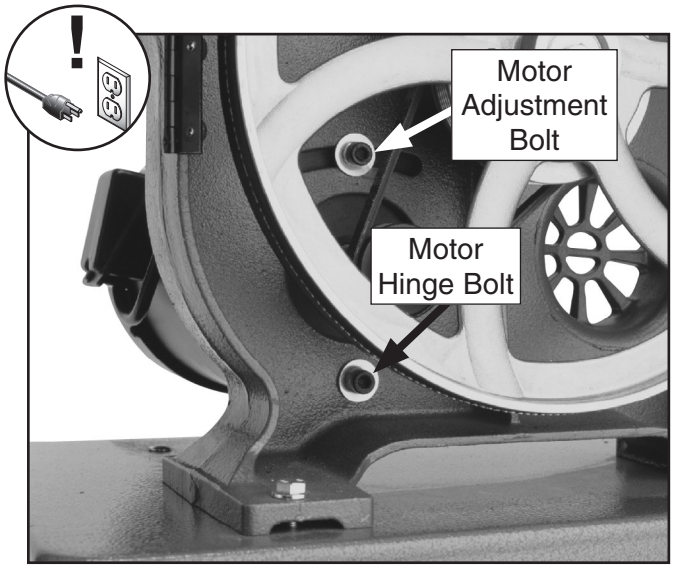


Figure 42. Motor mount bolts.

4. Move the body of the motor so the motor adjustment bolt slides to the left-hand side of the adjustment slot.

5. Hold the motor in position with one hand and tighten the motor adjustment bolt with the other hand.

6. Push the center of the belt. If deflection is approximately ¼" with moderate pressure from your thumb or finger, then the tension is correct. If the deflection is more than ¼", repeat **Steps 3–6**.

7. When the belt tension is correct, tighten the motor hinge bolt and close the lower wheel cover.

Replacing Belt

To replace the belt:

1. DISCONNECT BANDSAW FROM POWER!
2. Open both wheel covers.
3. Remove the bandsaw blade.
4. Loosen the motor mount bolts shown in **Figure 43**.

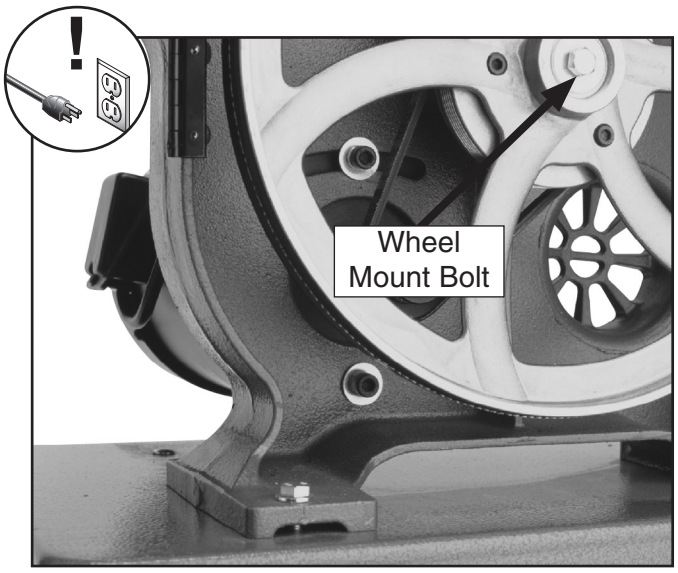


Figure 43. Wheel mount bolt.

5. Move the body of the motor so the motor adjustment bolt slides to the right-hand side of the adjustment slot.
6. Pull the belt off of the motor pulley.
7. Unthread the wheel mount bolt shown in **Figure 43,** and slide the lower wheel off of the bearing shaft.
8. Slip the old belt off of the wheel pulley and install the new belt in its place.
9. Re-install the lower wheel onto the bearing shaft, and replace/tighten the wheel mount bolt.
10. Position the belt over the motor pulley.
11. Move the body of the motor so the motor adjustment bolt slides to the left-hand side of the adjustment slot.
12. Hold the motor in position with one hand and tighten the motor adjustment bolt with the other hand.
13. Check the belt tension and adjust if necessary (see **Tensioning Belt** on **Page 38**).
14. When the belt tension is correct, tighten the motor hinge bolt and close the lower wheel cover.

Shimming Table

To ensure accuracy when cutting stacked workpieces, the table should be 90˚ to the back of the blade as shown in **Figure 44**. If the table is not perpendicular to the back of the blade, the table needs to be shimmed.

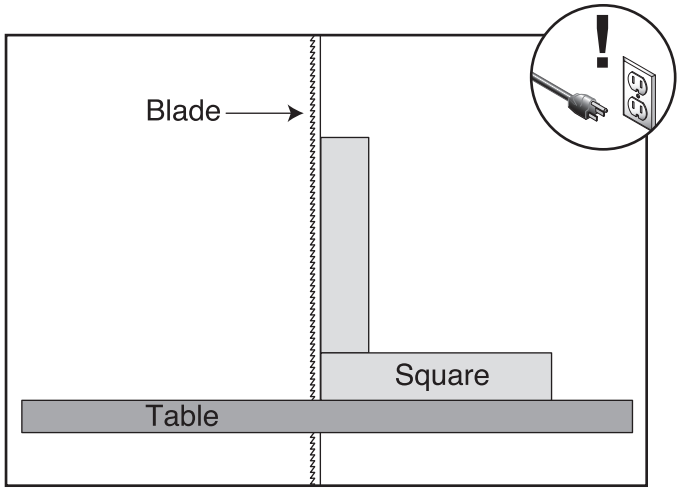


Figure 44. Squaring table to blade back.

To shim the table:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.

2. DISCONNECT BANDSAW FROM POWER!

3. Loosen the trunnion bolts that secure the trunnions to the table.

4. Place shim stock between the table and the two trunnions to shim the table in the desired direction.

   Note: *Another way to shim the table is to add washers between the table and the trunnion. Electrical washers are a good choice for this procedure because they are very thin and will allow for fine adjustment.*

5. Follow the **Aligning Miter Slot** instructions on **Page 24** to complete this procedure.

Blade Lead

"Blade Lead" means that the blade does not cut straight when using the fence or miter gauge (see **Figure 45**). This is a common condition with all bandsaws. Worn or damaged blades may cause lead and replacing them will fix the problem. Still, if your bandsaw is setup correctly and lead occurs, compensate for it by skewing the fence.

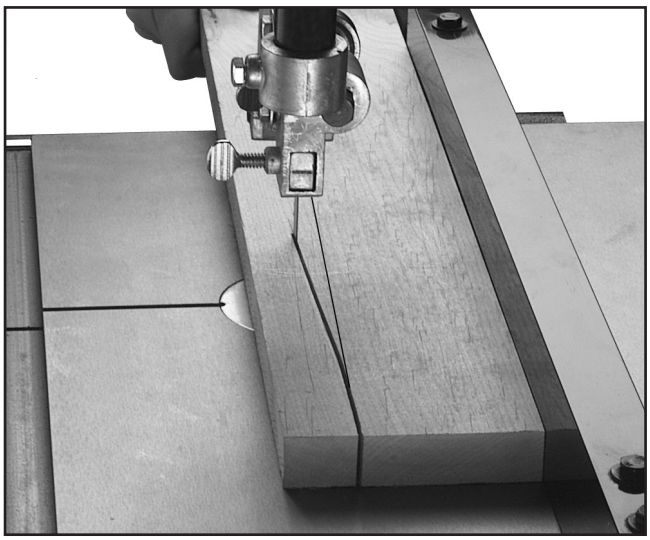


Figure 45. Blade leading away from line of cut.

To correct blade lead, do the following steps and make a test cut before skewing the fence:

1. Ensure that you have proper blade tension (refer to **Page 19**).

2. Ensure that the blade guides are adjusted correctly (refer to **Pages 19 & 21**).

3. Ensure that the miter slot or fence is parallel to the blade (refer to **Page 24**).

To skew your fence:

1. Cut a piece of scrap wood approximately ¾" thick x 3" wide x 17" long. On a wide face of the board, draw a straight line parallel to the long edge.

2. Slide the fence out of the way and cut free-hand along the line. Stop at the halfway point. Turn the bandsaw *OFF* and *wait for the blade to stop.*

3. Clamp the board to the bandsaw table without moving it. Now slide the fence over to the board so it barely touches one end of the board.

4. Loosen the four cap screws on top of the fence.

5. Skew the fence as needed until it is parallel to the edge of the scrap piece. You may need to re-adjust the fence locking mechanisms to gain maximum adjustment.

6. While maintaining the skew, tighten the cap screws.

To compensate for lead when making straight crosscuts with the miter gauge, you will need to shift the table:

1. Set the miter gauge to 90°.

2. On a scrap piece of wood, mark a line that is perpendicular to the front edge. Starting where the line begins, cut the board by pushing it through the blade with the miter gauge. *The miter gauge should be checked for square before beginning this procedure.*

3. Loosen the table mounting bolts, and shift the table to compensate for the blade lead.

4. Repeat **Steps 1 & 2** until the blade cuts straight when wood is pushed through with the miter gauge.

NOTICE

If the table is shifted, the fence will be affected since it is attached.

NOTICE

Lead adjustments will change when new blades are mounted on the saw.

Wheel Alignment

Wheel alignment is one of the easiest ways to ensure you get optimal performance from your bandsaw. When wheels are aligned, or coplanar, the bandsaw is more likely to cut straight without wandering; and vibration, heat, and blade wear are considerably decreased because the blade is automatically balanced on the wheel. This is known as "Coplanar Tracking."

To verify if the upper and lower wheels are coplanar:

1. DISCONNECT BANDSAW FROM POWER!

2. With the blade on and properly tensioned, hold a straightedge close to the center of both wheels. Make sure the straightedge fully extends across the wheels as shown in **Figure 46**.

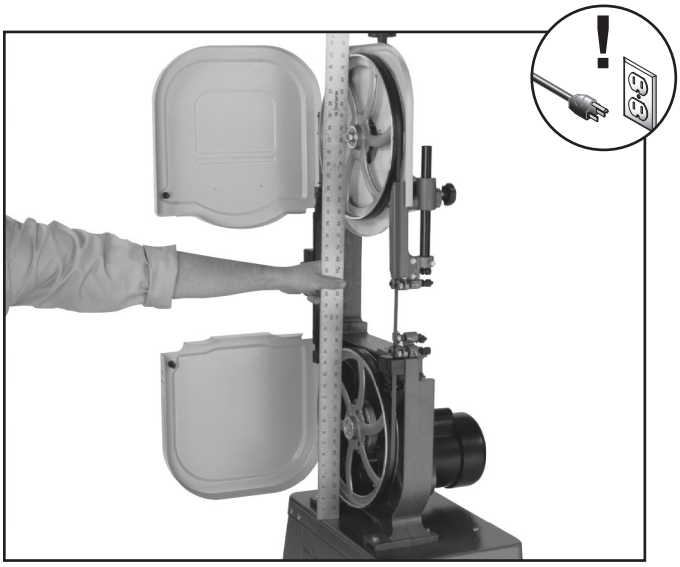


Figure 46. Checking wheel alignment with a straightedge.

—If the wheels are coplanar, the straightedge wil touch the top and bottom of the outside rims on each wheel.

—If your wheels are not coplanar, place the straightedge on the lower wheel first—ensuring that it touches both the top and bottom rim—and adjust the tracking knob to see how the upper wheel lines up with the straightedge.

—If the straightedge will not touch the top and bottom rim of the upper wheel evenly, determine which wheel sticks out farther. The wheel that does NOT stick out the farthest is the wheel that needs to be shimmed.

Shimming a wheel

1. Adjust the tracking knob so the top wheel is parallel with the bottom wheel. With the straightedge touching both points of the wheel that does not need to be adjusted, measure the distance away from the incorrect wheel with a fine ruler (see **Figure 47**). The distance measured with the ruler is the distance the wheel must be corrected.

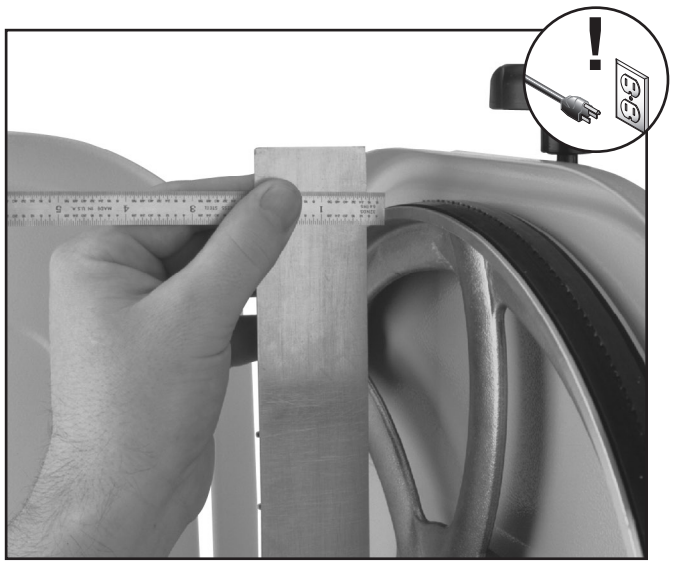


Figure 47. Measuring wheel difference.

2. Remove the blade from the saw, then remove the wheel that needs to be shimmed.

3. Shim washers work well because they are available in a wide range of thicknesses. Measure how many you need and place them on the mounting shaft.

4. Replace the wheel, any remaining washers, and the securing nut. Tighten the blade as it will be used during operation before you check the wheels. Often the wheels may be coplanar with the blade loose, then be pulled out of alignment when it is tightened.

5. The first time you get the wheels coplanar, place a mark on each wheel where you held the straightedge. This assures repeated accuracy every time you adjust your wheels.

When wheels are properly coplanar, the blade may not be centered on the crown of the wheel, but it will be balanced. See **Figure 48** to better understand coplanarity.

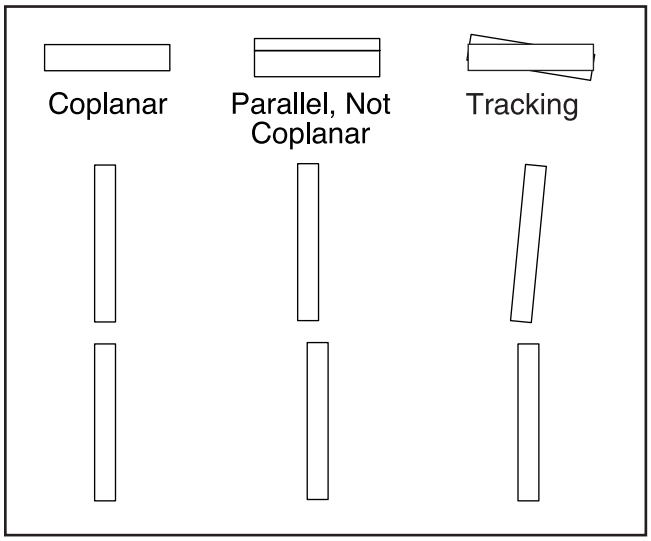


Figure 48. Coplanar diagram.

Blade Tensioner

Over the life of the machine, the blade tensioner system may need to be reset for correct operation.

To reset the blade tensioner:

1. DISCONNECT BANDSAW FROM POWER!

2. Release the tension lever shown in **Figure 49** and remove the bandsaw blade.

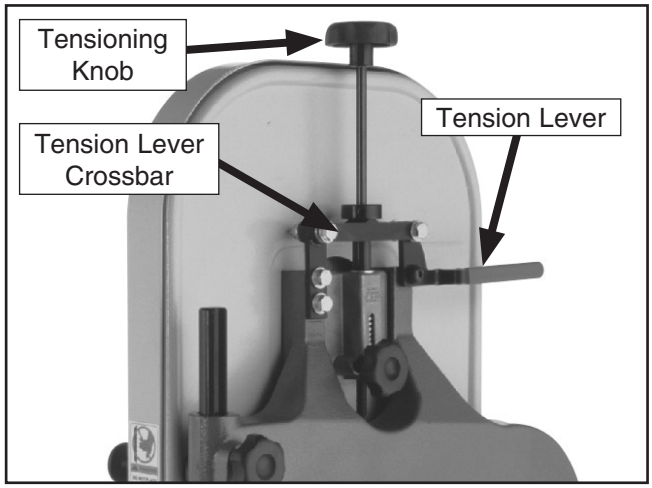


Figure 49. Blade tension controls/components.

3. Place the new blade onto the wheels and between the blade guide bearings.

   Note: *A new blade is used to calibrate the tensioner because it is unstretched.*

4. Loosen the setscrews in both of the spacers indicated in **Figure 50.**

5. Back the spacers away from the tension lever crossbar shown in **Figure 49**.

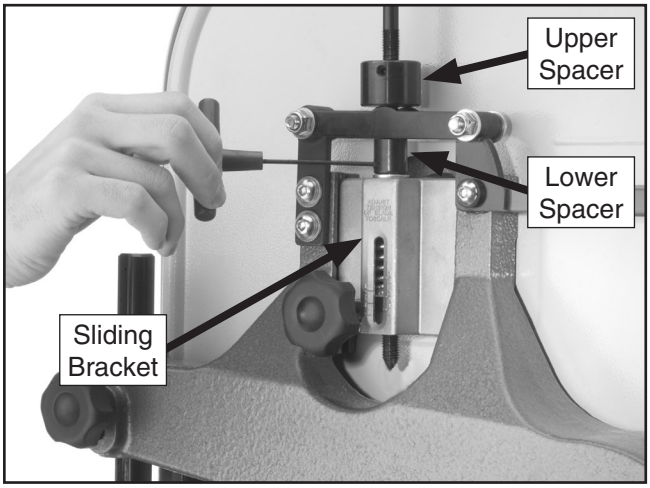


Figure 50. Loosening the spacer set screws.

6. Pull the tension lever down to the horizontal position.

7. Pull up on the tensioning knob (**Figure 49**) until the blade touches the wheel.

8. Thread the upper spacer down until it touches the top of the tension lever crossbar.

9. Tighten the setscrew on the upper spacer.

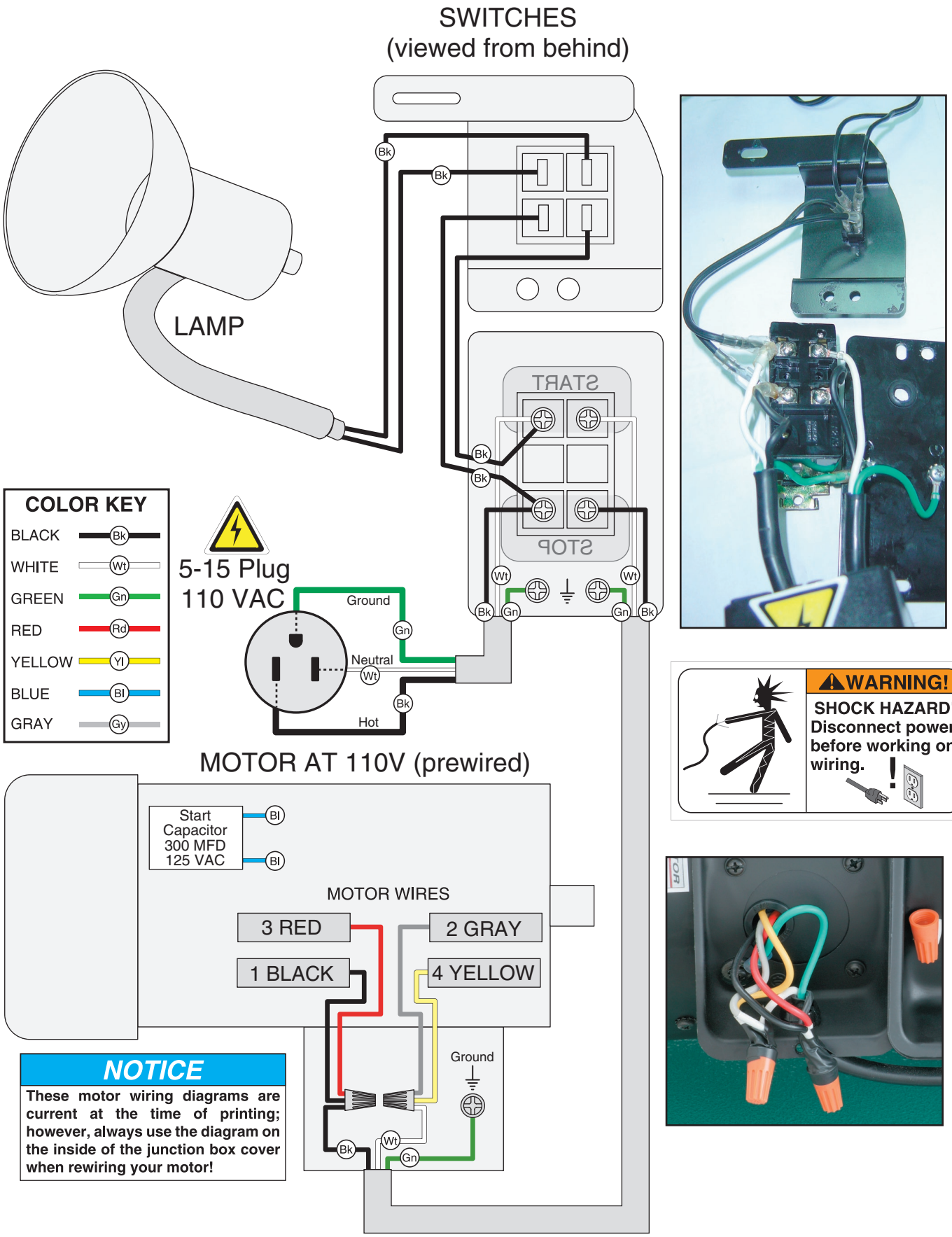
10. Tension the blade (refer to **Page 19**).

11. Thread the lower spacer down until it touches the top of the sliding bracket indicated in **Figure 50**.

12. Move the lower spacer back up the shaft about 1-2 turns to leave a small space, and tighten the setscrew (**Figure 50**).

13. Make sure there is no tension on the blade when the lever is released. If all the tension is not released, the lower spacer needs to be threaded farther down the shaft toward the sliding bracket.

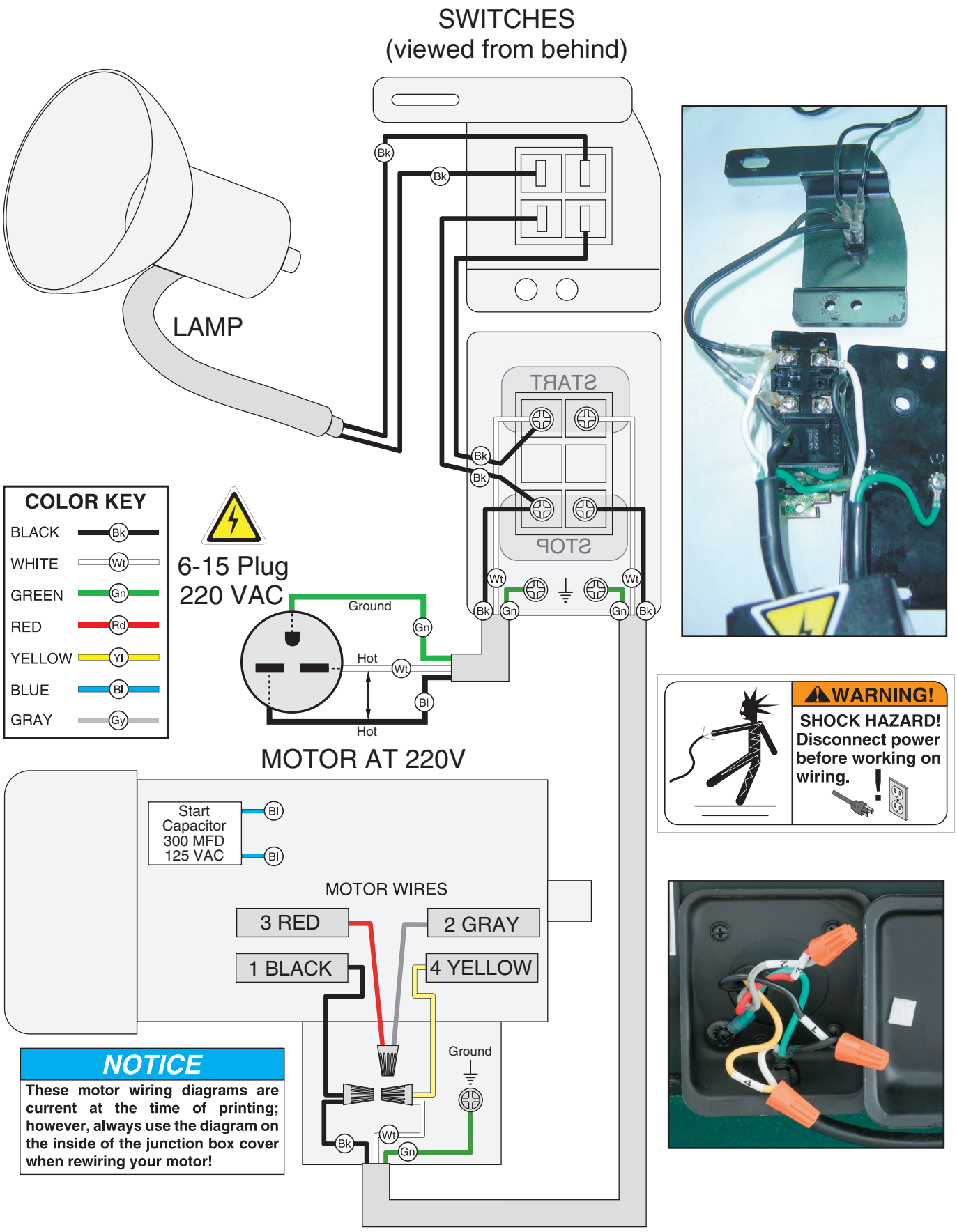
110V Wiring Diagram (Prewired)



NOTICE

These motor wiring diagrams are current at the time of printing; however, always use the diagram on the inside of the junction box cover when rewiring your motor!

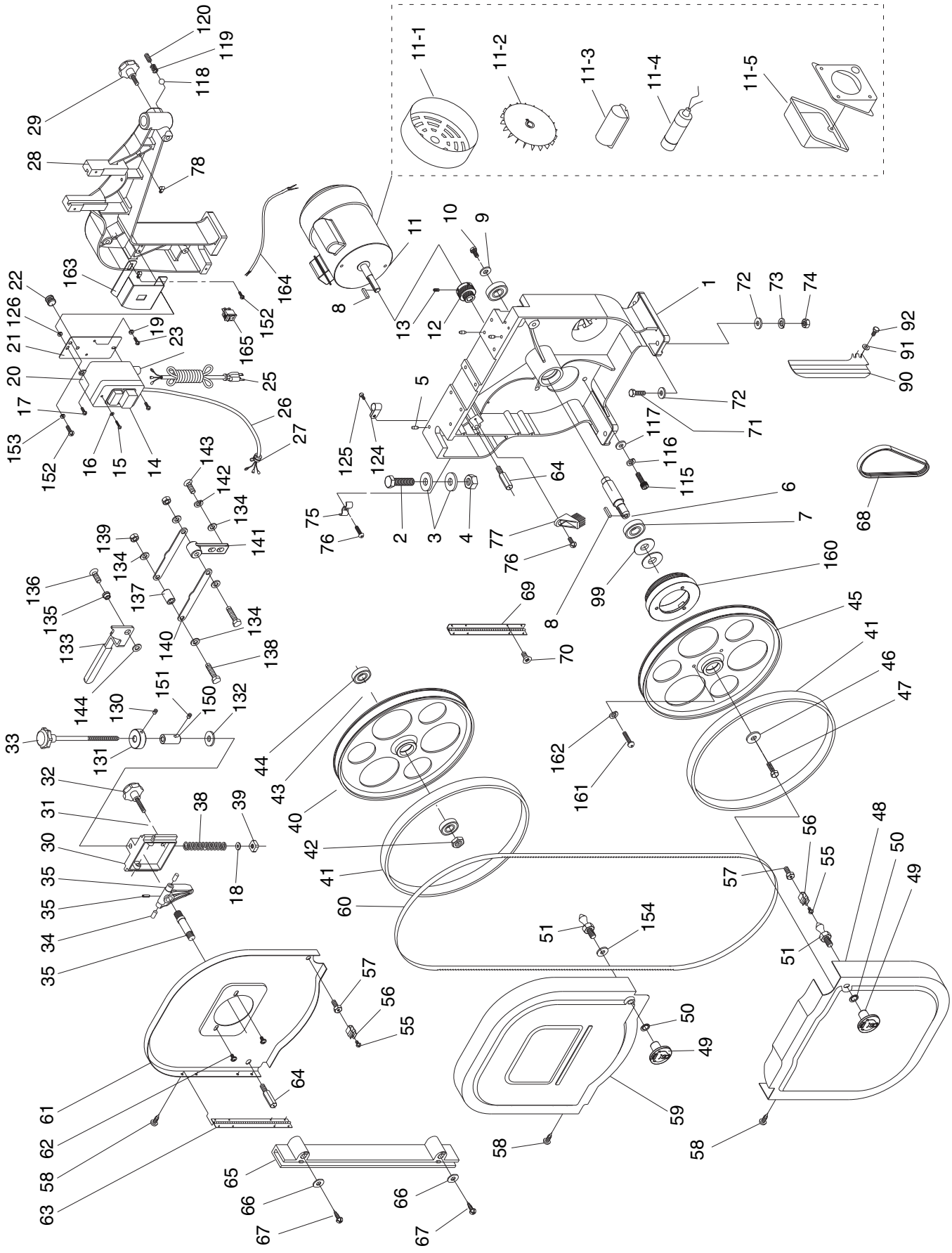
220V Wiring Diagram



NOTICE

These motor wiring diagrams are current at the time of printing; however, always use the diagram on the inside of the junction box cover when rewiring your motor!

Main Parts Breakdown



Main Parts List

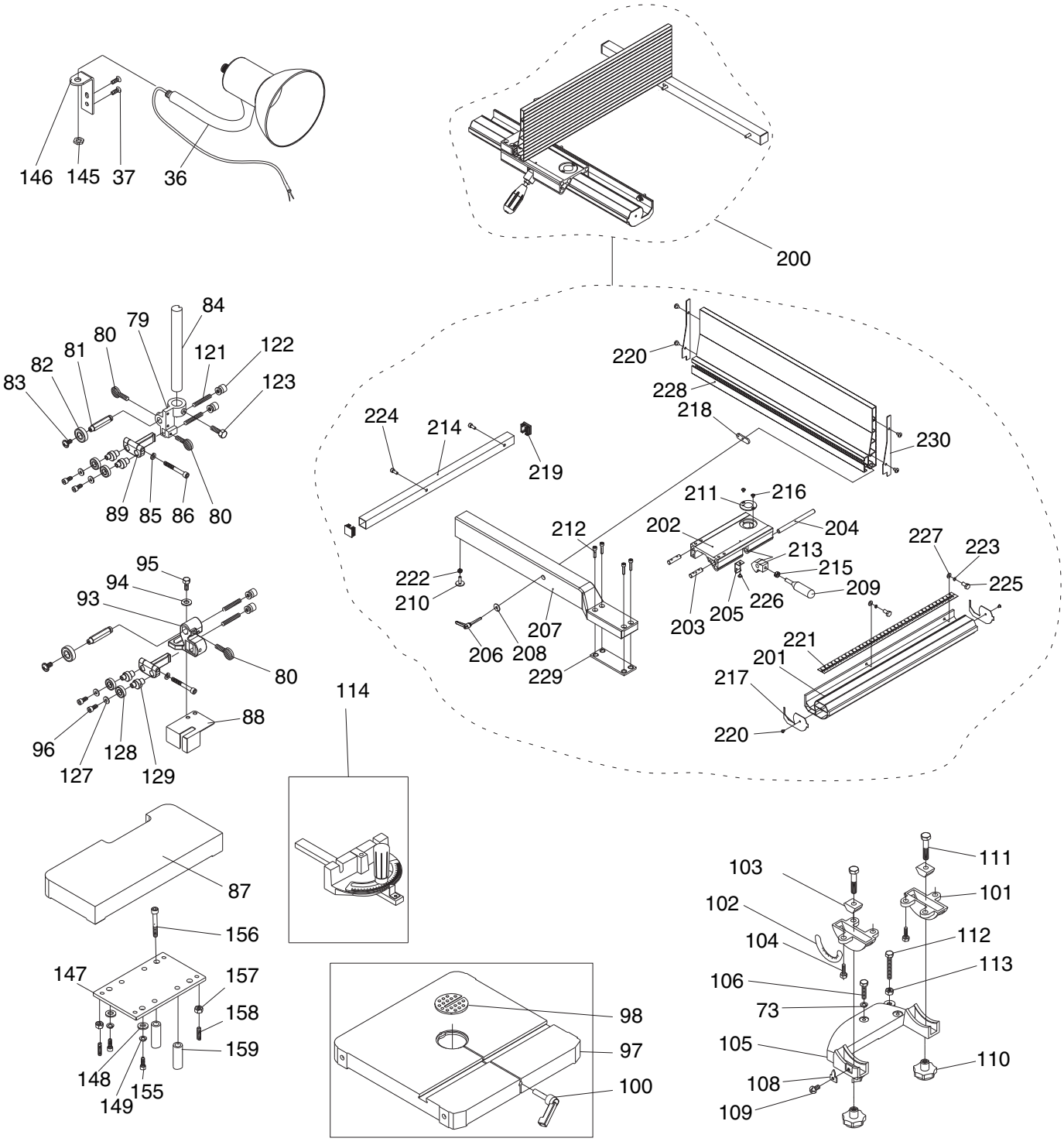
REF	PART #	DESCRIPTION
1	P0555X001	BASE
2	PB80M	HEX BOLT M16-2 X 55
3	P0555X003	SPECIAL WASHER 16MM
4	PN13M	HEX NUT M16-2
5	P0555X005	PIN
6	P0555X006	LOWER WHEEL SHAFT
7	P6204LLU	BALL BEARING 6204LLU
8	PK23M	KEY 5 X 5 X 25
9	P0513X045	FENDER WASHER 8MM
10	PSB11M	CAP SCREW M8-1.25 X 16
11	P0555X011	MOTOR 1.5 HP
11-1	P0555X011-1	MOTOR FAN COVER
11-2	P0555X011-2	MOTOR FAN
11-3	P0555X011-3	CAPACITOR COVER
11-4	P0555X011-4	CAPACITOR 300MFD 125VAC
11-5	P0555X011-5	JUNCTION BOX
12	P0555X012	MOTOR PULLEY
13	PSS04M	SET SCREW M6-1 X 12
14	P0555X014	SWITCH (PUSH BOTTON)
15	PHTEK1M	TAP SCREW M3.5 X 12
16	PW05M	FLAT WASHER 4MM
17	PS40M	PHLP HD SCR M5-.8 X 16
18	P0555X018	INDICATOR
19	PTLW02M	EXT TOOTH WASHER 5MM
20	P0555X020	SWITCH ENCLOSURE
21	P0555X021	SWITCH PLATE
22	P0555X022	GASKET
23	PS19M	PHLP HD SCR M5-.8 X 6
24	P0555X024	STRAIN RELIEF
25	P0555X025	POWER CORD
26	P0555X026	MOTOR CORD
27	P0555X027	STRAIN RELIEF
28	P0555X028	UPPER FRAME ARM
29	P0555X029	KNOB BOLT M10-1.5 X 30
30	P0555X030	HINGE BRACKET
31	P7945097	WING NUT 8MM
32	P0555X032	KNOB BOLT M8-1.25 X 45
33	P0555X033	ADJUSTING BOLT(ASM)
33-1	P0555X033-1	KNOB 8MM
33-2	P0555X033-2	ADJUSTING BOLT
33-3	PRP64M	ROLL PIN 3 X 18
34	P0555X034	STEEL PIN
35	P0555X035	UPPER WHEEL SHAFT HINGE (ASM)
35-1	P0555X035-1	UPPER WHEEL SHAFT
35-2	PRP04M	ROLL PIN 4 X 24
35-3	P0555X035-3	UPPER WHEEL SHAFT HINGE
38	P0555X038	COIL SPRING
39	PSN04M	SQUARE NUT M10-1.5
40	P0555X040	UPPER WHEEL
41	P0555X041	WHEEL TIRE
42	PN09M	HEX NUT M12-1.75
43	PR21M	INT RETAINING RING 35MM
44	P6202LLU	BALL BEARING 6202LLU
45	P0555X045	LOWER WHEEL
46	P0513X045	FENDER WASHER 8MM
47	PB81M	HEX BOLT M8-1.25 X 20 (LH)
48	P0555X048	LOWER WHEEL GUARD
49	P0555X049	GRIZZLY ROUND KNOB 8MM
50	PTLW03M	INT TOOTH WASHER 8MM
51	P0555X051	STUD LATCH
55	PS08M	PHLP HD SCR M5-.8 X 12
56	P0555X056	CATCH
57	P0555X057	LOCATING BOLT
58	PHTEK4M	TAP SCREW M4 X 8
59	P0555X059	COVER UPPER
60	P0555X060	SAW BLADE 6TPI 93-1/2"X3/8"X0.5MM
61	P0555X061	COVER UPPER BACK
62	PFS01M	FLANGE SCREW M5-.8 X 8
63	P0555X063	HINGE UPPER
64	P0555X064	STUD
65	P0555X065	SAW BLADE GUARD
66	P0555X066	GASKET
67	PHTEK2M	TAP SCREW M3.5 X 16
68	P0555068	BELT 2000J5
69	P0555X069	LOWER HINGE
70	PFH07M	FLAT HD SCR M5-.8 X 10
71	PB20M	HEX BOLT M8-1.25 X 35
72	P0555X072	FLAT WASHER M8-1.25 X 18
73	PLW04M	LOCK WASHER 8MM
74	PN03M	HEX NUT M8-1.25
75	P0555X075	CORD CLAMP
76	PS05M	PHLP HD SCR M5-.8 X 8
77	P0555X077	BRUSH WHEEL
78	P0555X078	CORD CLAMP 3/16"
90	P0555X090	BLADE GUARD (L)
91	PW03M	FLAT WASHER 6MM
92	PB04M	HEX BOLT M6-1 X 10
99	PW13M	FLAT WASHER 20MM

Main Parts List

REF	PART #	DESCRIPTION
115	PSB31M	CAP SCREW M8-1.25 X 25
116	PLW04M	LOCK WASHER 8MM
117	P0513X045	FENDER WASHER 8MM
118	P0555X118	STEEL BALL
119	P0555X119	COMPRESSION SPING
120	PSS30M	SET SCREW M10-1.5 X 10
124	P0555X124	CORD CLAMP
125	PS05M	PHLP HD SCR M5-.8 X 8
126	PLN01M	LOCK NUT M4-.7
130	PSS05M	SET SCREW M5-.8 X 10
131	P0555X131	FIXED LUMP
132	PW04M	FLAT WASHER 10MM
133	P0555X133	LEVER ROD
134	PW01M	FLAT WASHER 8MM
135	P0555X135	BUSHING
136	PSBS01M	BUTTON HD CAP SCR M8-125 X 20
137	P0555X137	BRACKET
138	PB15M	HEX BOLT M8-1.25 X 40

REF	PART #	DESCRIPTION
139	PLN04M	LOCK NUT M8-1.25
140	P0555X140	SUPPORT PLATE
141	P0555X141	FIXED BASE
142	PLW04M	LOCK WASHER 8MM
143	PSB14M	CAP SCREW M8-1.25 X 20
144	P0555X144	GASKET M8-1.25 X 20
150	P0555X150	FIXED RING
151	PSS07M	SET SCREW M5-.8 X 5
152	PS08M	PHLP HD SCR M5-.8 X 12
153	PTLW02M	EXT TOOTH WASHER 5MM
154	PW01M	FLAT WASHER 8MM
160	P0555X160	LOWER PULLEY
161	PSBS21	BUTTON HD CAP SCR M6-1 X 25
162	PLW03M	LOCK WASHER 6MM
163	P0555X163	SWITCH PLATE
164	P0555X164	LINE CORD
165	P0555X165	SWITCH

Secondary Parts Breakdown

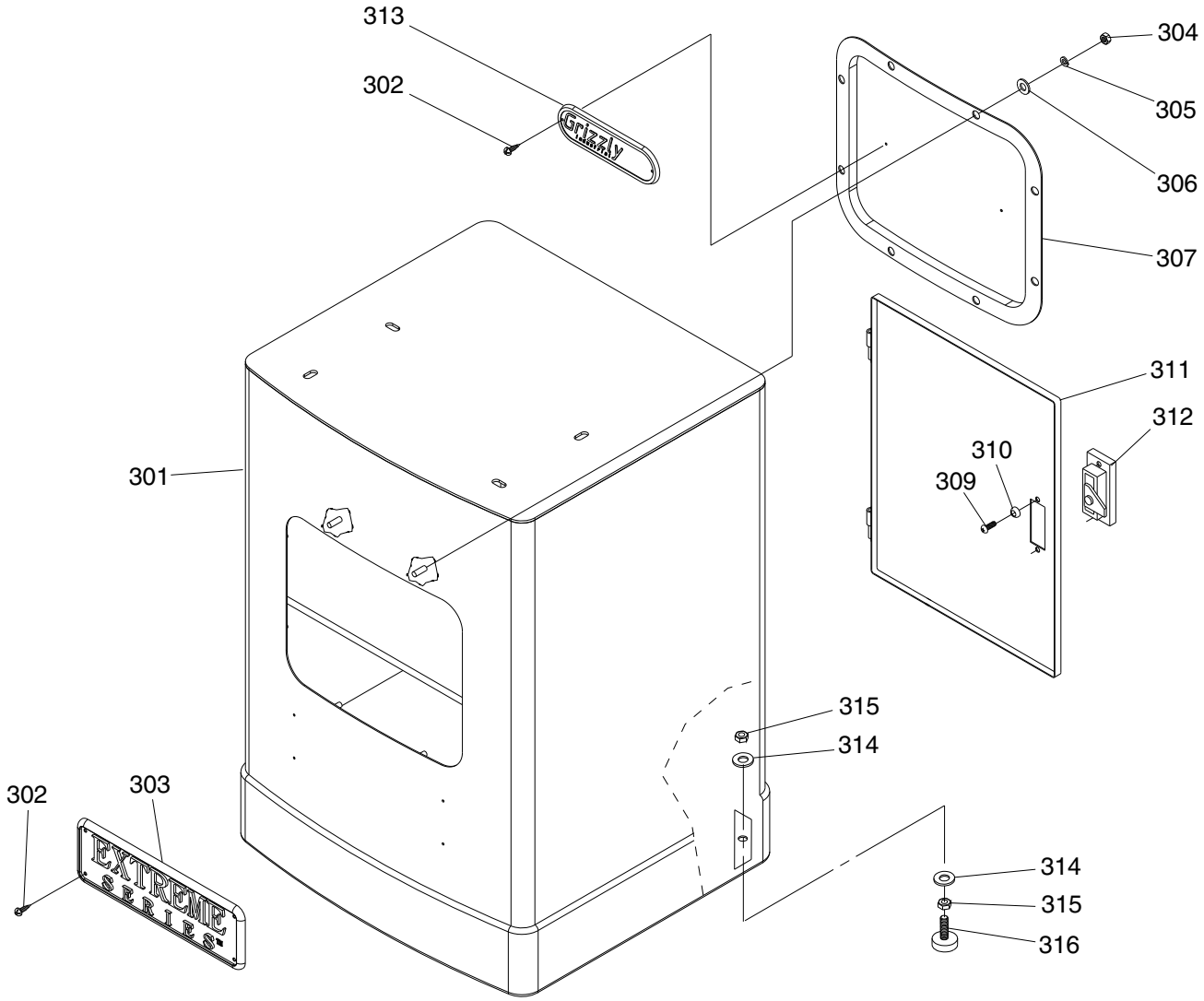


Secondary Parts Breakdown

REF	PART #	DESCRIPTION
36	P0555X036	LAMP
37	PFS01M	FLANGE SCREW M5-.8 X 8
73	PLW04M	LOCK WASHER 8MM
79	P0555X079	GUIDE SUPPORTER BRACKET
80	PTS001M	THUMB SCREW M6-1 X 16
81	P0555X081	UPPER SPACING SLEEVE
82	P6000	BALL BEARING 6000ZZ
83	PFS06M	FLANGE SCR M6-1 X 8
84	P0555X084	GUIDE POST
85	PLW01M	LOCK WASHER 5MM
86	PSB78M	CAP SCREW M5-.8 X 40
87	P0555X087	EXTENSION PLATE
88	P0555X088	LOWER BLADE GUARD
89	P0555X089	SUPPORT BRACKET
93	P0555X093	LOWER SUPPORT BRACKET POST
94	PW03M	FLAT WASHER 6MM
95	PB08M	HEX BOLT M6-1 X 20
96	PSB33M	CAP SCREW M5-.8 X 12
97	P0555X097	TABLE
98	P0555X098	TABLE INSERT
100	P0555X100	TABLE PIN
101	P0555X101	TRUNNION
102	P0555X102	SCALE
103	P0555X103	TRUNNION CLAMP SHOE
104	PB02M	HEX BOLT M6-1 X 12
105	P0555X105	TRUNNION SUPPORT BRACKET
106	PB26M	HEX BOLT M8-1.25 X 30
108	P0555X108	POINTER
109	PFS03M	FLANGE SCREW M5-.8 X 6
110	P0555X110	KNOB 10MM
111	PB73M	HEX BOLT M10-1.5 X 50
112	PB82M	HEX BOLT M8-1.25 X 80
113	PN03M	HEX NUT M8-1.25
114	P0555X114	MITER GAUGE BODY(ASM)
121	PSS44M	SET SCREW M8-1 X 40
122	P0555X122	MICRO ADJUSTING NUT
123	PB83M	HEX BOLT M6-1 X 16
127	PW02M	FLAT WASHER 5MM
128	P608	BALL BEARING 608ZZ
129	P0555X129	ECCENTRIC SHAFT
145	P0555X145	LAMP NUT

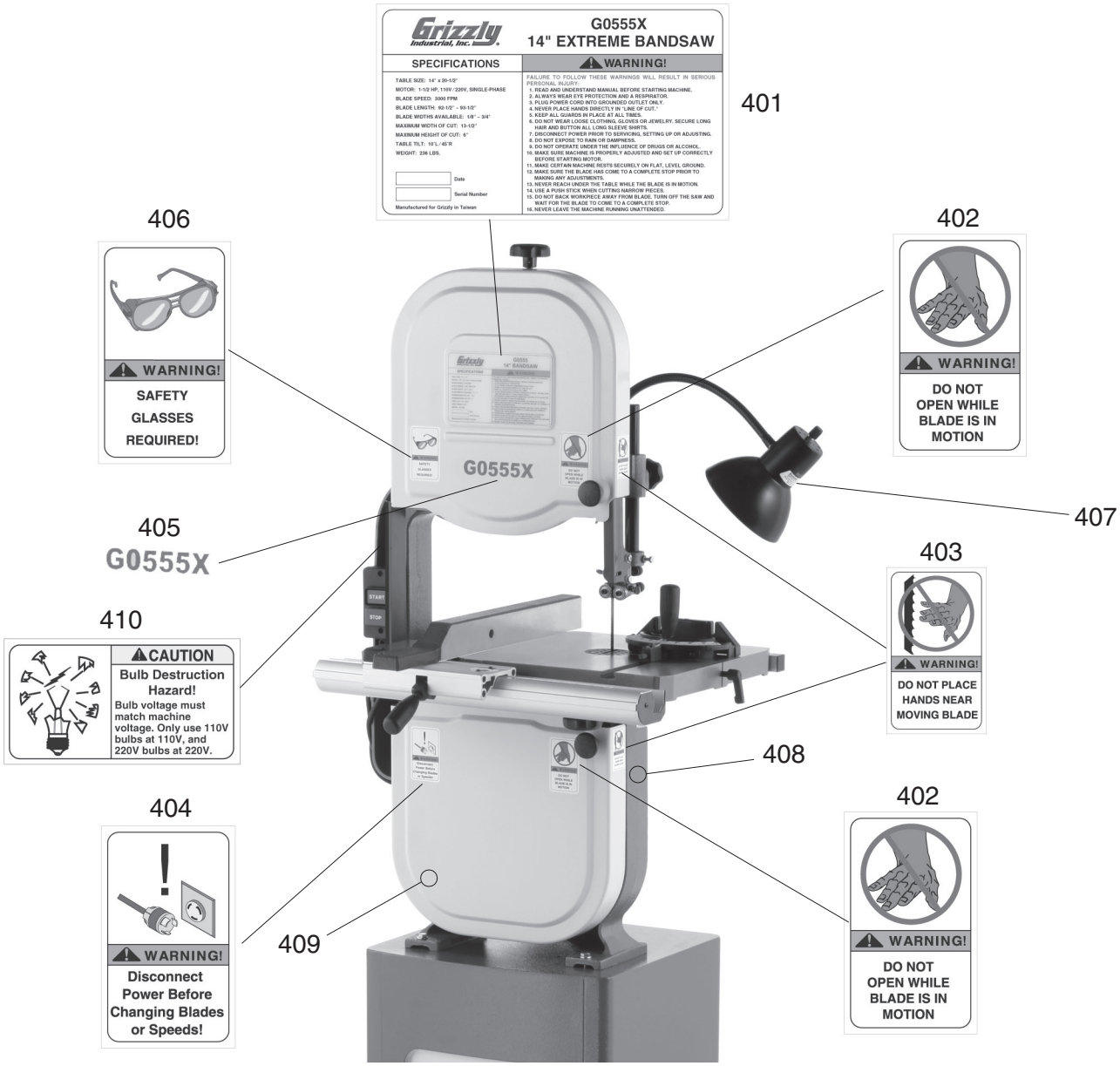
REF	PART #	DESCRIPTION
146	P0555X146	LAMP HOLDER
147	P0555X147	LEVER BOARD
148	PW03M	FLAT WASHER 6MM
149	PLW03M	LOCK WASHER 6MM
155	PSB06M	CAP SCREW M6-1 X 25
156	PSB35M	CAP SCREW M8-1.25 X 60
157	PN03M	HEX NUT M8-1.25
158	PSS09M	SET SCREW M8-1.25 X 20
159	P0555X159	SPACER
200	P0555X200	FENCE SET (ASM)
201	P0555X201	FIXED BASE 540MM
202	P0555X202	ADJUST BASE
203	P0555X203	FIXED SHAFT
204	P0555X204	SHAFT
205	P0555X205	SPRING PIECE
206	P0555X206	LOCK KNOB M8-1.25 X 44
207	P0555X207	SUPPORT TUBE 505MM
208	PW01M	FLAT WASHER 8MM
209	P0555X209	HANDLE
210	P0555X210	ADJUST SCREW
211	P0555X211	CONVEX
212	PSB06M	CAP SCREW M6-1 X 25
213	P0555X213	FIXED LUMP
214	P0555X214	SQURE TUBE 540MM
215	PN03M	HEX NUT M8-1.25
216	PFS04M	FLANGE SCREW M4-.7 X 6
217	P0555X217	GUARD PIECE
218	P0555X218	MOVING PLATE
219	P0555X219	PLUGGED
220	PHTEK3M	TAP SCREW M3.5 X 8
221	P0555X221	SCALE
222	PN01M	HEX NUT M6-1
223	PLW03M	LOCK WASHER 6MM
224	PSB01M	CAP SCREW M6-1 X 16
225	PB08M	HEX BOLT M6-1 X 20
226	P0555X226	FLANGE SCR M4-.7 X 8
227	PW03M	FLAT WASHER 6MM
228	P0555X228	FENCE (AL) 505MM
229	P0555X229	BRACKET T=3
230	P0555X230	END COVER

Stand Parts Breakdown



REF	PART #	DESCRIPTION
301	P0555X301	CLOSE STAND
302	PHTEK3M	TAP SCREW M3.5 X 8
303	P0555X303	EXTREME SERIES LOGO PLATE
304	PN01M	HEX NUT M6-1
305	PLW03M	LOCK WASHER 6MM
306	PW03M	FLAT WASHER 6MM
307	P0555X307	FACE PLATE
309	PS17M	PHLP HD SCR M4-.7 X 6
310	PW05M	FLAT WASHER 4MM
311	P0555X311	DOOR
312	P0555X312	DOOR LATCH (ASM)
313	P0555X313	GRIZZLY LOGO PLATE
314	PW04M	FLAT WASHER 10MM
315	PN08	HEX NUT 3/8-16
316	P0555X316	STAND FOOT

Labels Parts Breakdown



REF	PART #	DESCRIPTION
401	P0555X401	MACHINE ID LABEL
402	PLABEL-20	DON'T OPEN LABEL
403	PLABEL-19	HAND/BS BLADE LABEL
404	PLABEL-18	UNPLUG BANDSAW LABEL
405	P0555X405	G0555X MODEL NUMBER LABEL

REF	PART #	DESCRIPTION
406	PLABEL-11	WEAR SAFETY GLASSES LABEL
407	P0555X407	LAMP WARNING LABEL
408	P0555X408	"GRIZZLY GREEN" COLOR PAINT
409	P0555X409	"PUTTY" COLOR PAINT
410	P0555X410	BULB DESTRUCTION LABEL

⚠WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine MUST maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, REPLACE that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.

WARRANTY AND RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number,'' which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

Grizzly Industrial, Inc. WARRANTY CARD

Name _____

Street _____

City _____ State _____ Zip _____

Phone # _____ Email _____ Invoice # _____

Model # _____ Order # _____ Serial # _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. ***Of course, all information is strictly confidential.***

1. How did you learn about us?

____ Advertisement ____ Friend ____ Catalog
____ Card Deck ____ Website ____ Other:

2. Which of the following magazines do you subscribe to?

____ Cabinet Maker
____ Family Handyman
____ Hand Loader
____ Handy
____ Home Shop Machinist
____ Journal of Light Cont.
____ Live Steam
____ Model Airplane News
____ Modeltec
____ Old House Journal
____ Popular Mechanics
____ Popular Science
____ Popular Woodworking
____ Practical Homeowner
____ Precision Shooter
____ Projects in Metal
____ RC Modeler
____ Rifle
____ Shop Notes
____ Shotgun News
____ Today's Homeowner
____ Wood
____ Wooden Boat
____ Woodshop News
____ Woodsmith
____ Woodwork
____ Woodworker West
____ Woodworker's Journal
____ Other:

3. What is your annual household income?

____ $20,000-$29,000 ____ $30,000-$39,000 ____ $40,000-$49,000
____ $50,000-$59,000 ____ $60,000-$69,000 ____ $70,000+

4. What is your age group?

____ 20-29 ____ 30-39 ____ 40-49
____ 50-59 ____ 60-69 ____ 70+

5. How long have you been a woodworker/metalworker?

____ 0-2 Years ____ 2-8 Years ____ 8-20 Years ____ 20+ Years

6. How many of your machines or tools are Grizzly?

____ 0-2 ____ 3-5 ____ 6-9 ____ 10+

7. Do you think your machine represents a good value? _____ Yes _____ No

8. Would you recommend Grizzly Industrial to a friend? _____ Yes _____ No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?
Note: *We never use names more than 3 times.* _____ Yes _____ No

10. Comments: _____

_____

_____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

Place
Stamp
Here

GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069

FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name_____

Street_____

City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE